BIXOLON®

BIXOLON Printers
Unified Command Manual

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1. Notice

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2. Printer Models Supported

The control commands described in this document are utilized by at least one of the following printer models. The control commands available for the printer model are listed and detailed hereafter.

(1) Dot matrix printer
- SRP-270
- SRP-275
- SRP-280

(2) 2-inch direct thermal printer
- STP-103
- SRP-350N
- SRP-350plusN
- SRP-352plusN

(3) 3-inch direct thermal printer
STP-131
SRP-350
SRP-350plus
SRP-352plus

(4) 3-inch Black mark printer
SRP-350plusV
SRP-350plusM

(5) 2-inch mobile printer
SPP-R200

(6) 3-inch inkjet printer
SRP-500

We at BIXOLON maintain ongoing efforts to enhance and upgrade the functions and quality of all our products. In following, product specifications and/or user manual content may be changed without prior notice.

3. Control Commands List by Printer Model

3-1 STP-103 Supported Commands

No.	Command	Function
1	EOT	Transmit status
2	HT	Horizontal tab
3	LF	Print and line feed
4	CR	Print and carriage return
5	DLE	Set real-time command mode
6	DC4	Generate pulse
7	ESC SP	Set the character right space
8	ESC !	Set print mode
9	ESC $	Set absolute print position
10	ESC %	Select/cancel user-defined character set
11	ESC &	Define user-defined character set
12	ESC *	Specify bit image mode
13	ESC -	Turn underline mode on/off
14	ESC 2	Select default line spacing
15	ESC 3	Set line spacing
16	ESC =	Select peripheral device
17	ESC ?	Cancel user-defined characters
18	ESC @	Initialize printer
19	ESC D	Set horizontal tab positions
20	ESC E	Turn emphasized mode on/off
21	ESC G	Turn double-strike mode on/off
22	ESC J	Print and feed paper
23	ESC R	Specify an international character set
24	ESC V	Turn 90° clockwise rotation mode on/off

No.	Command	Function
25	ESC \	Set relative print position
26	ESC a	Set position alignment
27	ESC d	Print and feed n lines
28	ESC p	Generate pulse
29	ESC t	Select character code table
30	ESC {	Turn upside-down print mode on/off
31	FS p	Print NV bit image
32	FS q	Define NV bit image
33	GS !	Select character size
34	GS *	Define downloaded bit image
35	GS /	Print downloaded bit image
36	GS :	Start/end macro definition
37	GS B	Turn white/black reverse print mode on/off
38	GS H	Select print position of HRI characters
39	GS I	Transmit printer ID
40	GS L	Set left margin
41	GS W	Set print area width
42	GS ^	Execute macro
43	GS a	Enable/disable Automatic Status Back (ASB)
44	GS f	Select font for HRI characters
45	GS h	Set bar code height
46	GS k	Print bar code
47	GS v 0	Print raster bit image
48	GS w	Set bar code width

3-2 STP-131 Supported Commands

No.	Command	Function
1	EOT	Transmit status
2	HT	Horizontal tab
3	LF	Print and line feed
4	CR	Print and carriage return
5	DLE	Set real-time command mode
6	DC4	Generate pulse
7	ESC SP	Set the character right space
8	ESC !	Set print mode
9	ESC $	Set absolute print position
10	ESC %	Select/cancel user-defined character set
11	ESC &	Define user-defined character set
12	ESC *	Specify bit image mode
13	ESC -	Turn underline mode on/off
14	ESC 2	Select default line spacing
15	ESC 3	Set line spacing
16	ESC =	Select peripheral device
17	ESC ?	Cancel user-defined characters
18	ESC @	Initialize printer
19	ESC D	Set horizontal tab positions
20	ESC E	Turn emphasized mode on/off
21	ESC G	Turn double-strike mode on/off
22	ESC J	Print and feed paper
23	ESC R	Specify an international character set
24	ESC V	Turn 90° clockwise rotation mode on/off
25	ESC \	Set relative print position
26	ESC a	Set position alignment

No.	Command	Function
27	ESC d	Print and feed n lines
28	ESC i	Partial cut (one point left uncut)
29	ESC p	Generate pulse
30	ESC t	Select character code table
31	ESC {	Turn upside-down print mode on/off
32	FS p	Print NV bit image
33	FS q	Define NV bit image
34	GS !	Select character size
35	GS *	Define downloaded bit image
36	GS /	Print downloaded bit image
37	GS :	Start/end macro definition
38	GS B	Turn white/black reverse print mode on/off
39	GS H	Select print position of HRI characters
40	GS I	Transmit printer ID
41	GS L	Set left margin
42	GS V	Select cut mode and cut paper
43	GS W	Set print area width
44	GS ^	Execute macro
45	GS a	Enable/disable Automatic Status Back (ASB)
46	GS f	Select font for HRI characters
47	GS h	Set bar code height
48	GS k	Print bar code
49	GS r	Transmit status
50	GS v 0	Print raster bit image
51	GS w	Set bar code width

3-3 SPP-R200 Supported Commands

No.	Command	Function
1	EOT	Transmit status
2	BS L A	Execute automatic calibration in label mode
3	BS L L	Select label mode
4	BS L R	Select receipt mode
5	BS ^ E	Set NV user memory area
6	BS ^ L BS ^ 7	Select graphics data
7	HT	Horizontal tab
8	LF	Print and line feed
9	FF	Form feed (in page mode)
10	CR	Print and carriage return
11	DLE	Set real-time command mode
12	CAN	Cancel the print data in page mode
13	ESC FF	Print data in page mode
14	ESC SP	Set the character right space
15	ESC !	Set print mode
16	ESC $	Set absolute print position
17	ESC *	Specify bit image mode
18	ESC -	Turn underline mode on/off
19	ESC 2	Select default line spacing
20	ESC 3	Set line spacing
21	ESC @	Initialize printer
22	ESC D	Set horizontal tab positions
23	ESC E	Turn emphasized mode on/off
24	ESC G	Turn double-strike mode on/off
25	ESC J	Print and feed paper
26	ESC L	Select page mode
27	ESC M	Select character font/ MSR card read
28	ESC R	Specify an international character set
29	ESC S	Select standard mode

No.	Command	Function
30	ESC T	Select print direction in page mode
31	ESC W	Set print area in page mode
32	ESC \	Set relative print position
33	ESC a	Set position alignment
34	ESC d	Print and feed n lines
35	ESC t	Select character code table
36	ESC {	Turn upside-down print mode on/off
37	FS &	Select Kanji character mode
38	FS .	Cancel Kanji character mode
39	GS !	Select character size
40	GS $	Set absolute vertical print position in page mode
41	GS (A	Execute test print
42	GS (k	Specify and print the symbol
43	GS :	Start/end macro definition
44	GS B	Turn white/black reverse print mode on/off
45	GS H	Select print position of HRI characters
46	GS I	Transmit printer ID
47	GS I b	Transmit battery status
48	GS L	Set left margin
49	GS W	Set print area width
50	GS \	Set relative vertical print position in page mode
51	GS ^	Execute macro
52	GS f	Select font for HRI characters
53	GS h	Set bar code height
54	GS k	Print bar code
55	GS r	Transmit status
56	GS v 0	Print raster bit image
57	GS w	Set bar code width

3-4 SRP-270 Supported Commands

No.	Command	Function
1	EOT	Transmit status
2	HT	Horizontal tab
3	LF	Print and line feed
4	CR	Print and carriage return
5	DLE	Set real-time command mode
6	DC4	Generate pulse
7	ESC SP	Set the character right space
8	ESC !	Set print mode
9	ESC %	Select/cancel user-defined character set
10	ESC &	Define user-defined character set
11	ESC *	Specify bit image mode
12	ESC -	Turn underline mode on/off
13	ESC 2	Select default line spacing
14	ESC 3	Set line spacing
15	ESC <	Return home
16	ESC =	Select peripheral device
17	ESC ?	Cancel user-defined characters
18	ESC @	Initialize printer
19	ESC D	Set horizontal tab positions
20	ESC E	Turn emphasized mode on/off

No.	Command	Function
21	ESC G	Turn double-strike mode on/off
22	ESC J	Print and feed paper
23	ESC K	Print and reverse feed
24	ESC R	Specify an international character set
25	ESC U	Specify unidirectional print mode
26	ESC a	Set position alignment
27	ESC d	Print and feed n lines
28	ESC e	Print and reverse feed n lines
29	ESC i	Partial cut (one point left uncut)
30	ESC m	Partial cut (one point left uncut)
31	ESC p	Generate pulse
32	ESC r	Select print color
33	ESC t	Select character code table
34	ESC u	Transmit peripheral device status
35	ESC v	Transmit paper sensor status
36	ESC {	Turn upside-down print mode on/off
37	GS I	Transmit printer ID
38	GS V	Select cut mode and cut paper
39	GS a	Enable/disable Automatic Status Back (ASB)
40	GS r	Transmit status

3-5 SRP-275 Supported Commands

No.	Command	Function
1	EOT	Transmit status
2	ENQ	Request to printer
3	BS ^ E	Set NV user memory area
4	HT	Horizontal tab
5	LF	Print and line feed
6	CR	Print and carriage return
7	DLE	Set real-time command mode
8	DC4	Generate pulse
9	ESC SP	Set the character right space
10	ESC !	Set print mode
11	ESC %	Select/cancel user-defined character set
12	ESC &	Define user-defined character set
13	ESC *	Specify bit image mode
14	ESC -	Turn underline mode on/off
15	ESC 2	Select default line spacing
16	ESC 3	Set line spacing
17	ESC <	Return home
18	ESC =	Select peripheral device
19	ESC ?	Cancel user-defined characters
20	ESC @	Initialize printer
21	ESC D	Set horizontal tab positions
22	ESC E	Turn emphasized mode on/off
23	ESC G	Turn double-strike mode on/off
24	ESC J	Print and feed paper
25	ESC K	Print and reverse feed
26	ESC M	Select character font/ MSR card read
27	ESC R	Specify an international character set
28	ESC R S	Stores international character set to NV memory
29	ESC U	Specify unidirectional print mode

No.	Command	Function
30	ESC a	Set position alignment
31	ESC d	Print and feed n lines
32	ESC e	Print and reverse feed n lines
33	ESC g 0	Define macro (For logo)
34	ESC g n	Execute macro (For logo)
35	ESC i	Partial cut (one point left uncut)
36	ESC m	Partial cut (one point left uncut)
37	ESC p	Generate pulse
38	ESC r	Select print color
39	ESC t	Select character code table
40	ESC u	Transmit peripheral device status
41	ESC v	Transmit paper sensor status
42	ESC {	Turn upside-down print mode on/off
43	FS !	Set print mode for Kanji characters
44	FS &	Select Kanji character mode
45	FS -	Turn underline mode on/off for Kanji characters
46	FS .	Cancel Kanji character mode
47	FS 2	Specify user-defined Kanji characters
48	FS p	Print NV bit image
49	FS q	Define NV bit image
50	FS S	Set Kanji character spacing
51	FS W	Turn quadruple-size mode on/off for Kanji characters
52	FS ?	Cancel user-defined Kanji characters
53	GS (A	Execute test print
54	GS I	Transmit printer ID
55	GS V	Select cut mode and cut paper
56	GS a	Enable/disable Automatic Status Back (ASB)
57	GS r	Transmit status

3-6 SRP-280 Supported Commands

No.	Command	Function
1	EOT	Transmit status
2	HT	Horizontal tab
3	LF	Print and line feed
4	CR	Print and carriage return
5	DLE	Set real-time command mode
6	DC4	Generate pulse
7	ESC SP	Set the character right space
8	ESC !	Set print mode
9	ESC %	Select/cancel user-defined character set
10	ESC &	Define user-defined character set
11	ESC *	Specify bit image mode
12	ESC -	Turn underline mode on/off
13	ESC 2	Select default line spacing
14	ESC 3	Set line spacing
15	ESC <	Return home
16	ESC =	Select peripheral device
17	ESC ?	Cancel user-defined characters
18	ESC @	Initialize printer
19	ESC D	Set horizontal tab positions
20	ESC E	Turn emphasized mode on/off
21	ESC G	Turn double-strike mode on/off

No.	Command	Function
22	ESC J	Print and feed paper
23	ESC K	Print and reverse feed
24	ESC R	Specify an international character set
25	ESC U	Specify unidirectional print mode
26	ESC a	Set position alignment
27	ESC d	Print and feed n lines
28	ESC e	Print and reverse feed n lines
29	ESC i	Partial cut (one point left uncut)
30	ESC m	Partial cut (one point left uncut)
31	ESC p	Generate pulse
32	ESC t	Select character code table
33	ESC u	Transmit peripheral device status
34	ESC {	Turn upside-down print mode on/off
35	FS !	Set print mode for Kanji characters
36	FS -	Turn underline mode on/off for Kanji characters
37	FS S	Set Kanji character spacing
38	GS I	Transmit printer ID
39	GS V	Select cut mode and cut paper
40	GS a	Enable/disable Automatic Status Back (ASB)
41	GS r	Transmit status

3-7 SRP-350, SRP-350N Supported Commands

No.	Command	Function
1	EOT	Transmit status
2	ENQ	Request to printer
3	HT	Horizontal tab
4	LF	Print and line feed
5	FF	Form feed (in page mode)
6	CR	Print and carriage return
7	DLE	Set real-time command mode
8	CAN	Cancel the print data in page mode
9	DC4	Generate pulse
10	ESC SP	Set the character right space
11	ESC !	Set print mode
12	ESC $	Set absolute print position
13	ESC %	Select/cancel user-defined character set
14	ESC &	Define user-defined character set
15	ESC *	Specify bit image mode
16	ESC -	Turn underline mode on/off
17	ESC 2	Select default line spacing
18	ESC 3	Set line spacing
19	ESC =	Select peripheral device
20	ESC ?	Cancel user-defined characters
21	ESC @	Initialize printer
22	ESC D	Set horizontal tab positions
23	ESC E	Turn emphasized mode on/off
24	ESC G	Turn double-strike mode on/off
25	ESC J	Print and feed paper
26	ESC L	Select page mode
27	ESC M	Select character font/ MSR card read
28	ESC R	Specify an international character set
29	ESC S	Select standard mode
30	ESC T	Select print direction in page mode

No.	Command	Function
31	ESC V	Turn 90° clockwise rotation mode on/off
32	ESC W	Set print area in page mode
33	ESC \	Set relative print position
34	ESC a	Set position alignment
35	ESC d	Print and feed n lines
36	ESC p	Generate pulse
37	ESC t	Select character code table
38	ESC {	Turn upside-down print mode on/off
39	FS p	Print NV bit image
40	FS q	Define NV bit image
41	GS !	Select character size
42	GS $	Set absolute vertical print position in page mode
43	GS *	Define downloaded bit image
44	GS /	Print downloaded bit image
45	GS :	Start/end macro definition
46	GS B	Turn white/black reverse print mode on/off
47	GS H	Select print position of HRI characters
48	GS I	Transmit printer ID
49	GS L	Set left margin
50	GS V	Select cut mode and cut paper
51	GS W	Set print area width
52	GS \	Set relative vertical print position in page mode
53	GS ^	Execute macro
54	GS a	Enable/disable Automatic Status Back (ASB)
55	GS f	Select font for HRI characters
56	GS h	Set bar code height
57	GS k	Print bar code
58	GS r	Transmit status
59	GS v 0	Print raster bit image
60	GS w	Set bar code width

3-8 SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN Supported Commands

No.	Command	Function
1	EOT	Transmit status
2	BS ^ E	Set NV user memory area
3	BS ^ L BS ^ 7	Select graphics data
4	HT	Horizontal tab
5	LF	Print and line feed
6	FF	Form feed (in page mode)
7	CR	Print and carriage return
8	DLE	Set real-time command mode
9	CAN	Cancel the print data in page mode
10	DC4	Generate pulse
11	ESC SP	Set the character right space
12	ESC !	Set print mode
13	ESC $	Set absolute print position
14	ESC %	Select/cancel user-defined character set
15	ESC &	Define user-defined character set
16	ESC *	Specify bit image mode
17	ESC -	Turn underline mode on/off
18	ESC 2	Select default line spacing
19	ESC 3	Set line spacing
20	ESC =	Select peripheral device
21	ESC ?	Cancel user-defined characters
22	ESC @	Initialize printer
23	ESC D	Set horizontal tab positions
24	ESC E	Turn emphasized mode on/off
25	ESC G	Turn double-strike mode on/off

No.	Command	Function
26	ESC J	Print and feed paper
27	ESC L	Select page mode
28	ESC M	Select character font/ MSR card read
29	ESC R	Specify an international character set
30	ESC S	Select standard mode
31	ESC T	Select print direction in page mode
32	ESC V	Turn 90° clockwise rotation mode on/off
33	ESC W	Set print area in page mode
34	ESC \	Set relative print position
35	ESC a	Set position alignment
36	ESC d	Print and feed n lines
37	ESC i	Partial cut
38	ESC m	Partial cut
39	ESC p	Generate pulse
40	ESC t	Select character code table
41	ESC v	Transmit paper sensor status
42	ESC {	Turn upside-down print mode on/off
43	FS p	Print NV bit image
44	FS q	Define NV bit image
45	GS !	Select character size
46	GS $	Set absolute vertical print position in page mode
47	GS (A	Execute test print
48	GS (N	Select character color
49	GS (k	Specify and print the symbol
50	GS *	Define downloaded bit image

No.	Command	Function
51	GS /	Print downloaded bit image
52	GS :	Start/end macro definition
53	GS B	Turn white/black reverse print mode on/off
54	GS H	Select print position of HRI characters
55	GS I	Transmit printer ID
56	GS L	Set left margin
57	GS T	Set print position to the beginning of print line
58	GS V	Select cut mode and cut paper
59	GS W	Set print area width
60	GS \	Set relative vertical print position in page mode
61	GS ^	Execute macro
62	GS a	Enable/disable Automatic Status Back (ASB)
63	GS f	Select font for HRI characters
64	GS h	Set bar code height
65	GS k	Print bar code
66	GS r	Transmit status
67	GS v 0	Print raster bit image
68	GS w	Set bar code width

3-9 SRP-350plusV, SRP-350plusM Supported Commands

No.	Command	Function
1	EOT	Transmit status
2	BS ^ E	Set NV user memory area
3	BS ^ L BS ^ 7	Select graphics data
4	HT	Horizontal tab
5	LF	Print and line feed
6	FF	Print and feed paper to print starting position
7	CR	Print and carriage return
8	DLE	Set real-time command mode
9	CAN	Cancel the print data in page mode
10	DC4	Generate pulse
11	ESC SP	Set the character right space
12	ESC !	Set print mode
13	ESC $	Set absolute print position
14	ESC %	Select/cancel user-defined character set
15	ESC &	Define user-defined character set
16	ESC *	Specify bit image mode
17	ESC -	Turn underline mode on/off
18	ESC 2	Select default line spacing
19	ESC 3	Set line spacing
20	ESC =	Select peripheral device
21	ESC ?	Cancel user-defined characters
22	ESC @	Initialize printer
23	ESC D	Set horizontal tab positions
24	ESC E	Turn emphasized mode on/off
25	ESC G	Turn double-strike mode on/off
26	ESC J	Print and feed paper

No.	Command	Function
27	ESC L	Select page mode
28	ESC M	Select character font/ MSR card read
29	ESC R	Specify an international character set
30	ESC S	Select standard mode
31	ESC T	Select print direction in page mode
32	ESC V	Turn 90° clockwise rotation mode on/off
33	ESC W	Set print area in page mode
34	ESC \	Set relative print position
35	ESC a	Set position alignment
36	ESC d	Print and feed n lines
37	ESC i	Partial cut
38	ESC m	Partial cut
39	ESC p	Generate pulse
40	ESC t	Select character code table
41	ESC v	Transmit paper sensor status
42	ESC {	Turn upside-down print mode on/off
43	FS p	Print NV bit image
44	FS q	Define NV bit image
45	GS !	Select character size
46	GS $	Set absolute vertical print position in page mode
47	GS (A	Execute test print
48	GS (F	Set black mark control functions
49	GS (N	Select character color
50	GS (k	Specify and print the symbol
51	GS *	Define downloaded bit image
52	GS /	Print downloaded bit image

No.	Command	Function
53	GS :	Start/end macro definition
54	GS <	Black mark initialization
55	GS B	Turn white/black reverse print mode on/off
56	GS H	Select print position of HRI characters
57	GS I	Transmit printer ID
58	GS L	Set left margin
59	GS T	Set print position to the beginning of print line
60	GS V	Select cut mode and cut paper
61	GS W	Set print area width
62	GS \	Set relative vertical print position in page mode
63	GS ^	Execute macro
64	GS a	Enable/disable Automatic Status Back (ASB)
65	GS f	Select font for HRI characters
66	GS h	Set bar code height
67	GS k	Print bar code
68	GS r	Transmit status
69	GS v 0	Print raster bit image
70	GS w	Set bar code width

3-10 SRP-500 Supported Commands

No.	Command	Function
1	EOT	Transmit status
2	ENQ	Request to printer
3	BS ^ E	Set NV user memory area
4	HT	Horizontal tab
5	LF	Print and line feed
6	CR	Print and carriage return
7	DLE	Set real-time command mode
8	ESC SP	Set the character right space
9	ESC !	Set print mode
10	ESC %	Select/cancel user-defined character set
11	ESC &	Define user-defined character set
12	ESC *	Specify bit image mode
13	ESC -	Turn underline mode on/off
14	ESC 2	Select default line spacing
15	ESC 3	Set line spacing
16	ESC <	Return home
17	ESC =	Select peripheral device
18	ESC ?	Cancel user-defined characters
19	ESC @	Initialize printer
20	ESC D	Set horizontal tab positions
21	ESC E	Turn emphasized mode on/off

No.	Command	Function
22	ESC G	Turn double-strike mode on/off
23	ESC J	Print and feed paper
24	ESC R	Specify an international character set
25	ESC U	Specify unidirectional print mode
26	ESC a	Set position alignment
27	ESC d	Print and feed n lines
28	ESC g 0	Define macro (For logo)
29	ESC g n	Execute macro (For logo)
30	ESC m	Partial cut (one point left uncut)
31	ESC p	Generate pulse
32	ESC r	Select print color
33	ESC t	Select character code table
34	ESC u	Transmit peripheral device status
35	ESC v	Transmit paper sensor status
36	ESC {	Turn upside-down print mode on/off
37	GS (A	Execute test print
38	GS I	Transmit printer ID
39	GS V	Select cut mode and cut paper
40	GS a	Enable/disable Automatic Status Back (ASB)
41	GS r	Transmit status

4. Control Commands List in Alphanumeric Order

No.	Command	Function
1	**EOT**	Transmit status
2	**ENQ**	Request to printer
3	**BS L A**	Execute automatic calibration in label mode
4	**BS L L**	Select label mode
5	**BS L R**	Select receipt mode
6	**BS ^ E**	Set NV user memory area
7	**BS ^ L** **BS ^ 7**	Select graphics data
8	**HT**	Horizontal tab
9	**LF**	Print and line feed
10	**FF**	Form feed (in page mode)
11	**CR**	Print and carriage return
12	**DLE**	Set real-time command mode
13	**CAN**	Cancel the print data in page mode
14	**DC4**	Generate pulse
15	**ESC FF**	Print data in page mode
16	**ESC SP**	Set the character right space
17	**ESC !**	Set print mode
18	**ESC $**	Set absolute print position
19	**ESC %**	Select/cancel user-defined character set
20	**ESC &**	Define user-defined character set
21	**ESC ***	Specify bit image mode
22	**ESC -**	Turn underline mode on/off
23	**ESC 2**	Select default line spacing
24	**ESC 3**	Set line spacing
25	**ESC <**	Return home
26	**ESC =**	Select peripheral device
27	**ESC ?**	Cancel user-defined characters
28	**ESC @**	Initialize printer
29	**ESC D**	Set horizontal tab positions

No.	Command	Function
30	**ESC E**	Turn emphasized mode on/off
31	**ESC G**	Turn double-strike mode on/off
32	**ESC J**	Print and feed paper
33	**ESC K**	Print and reverse feed
34	**ESC L**	Select page mode
35	**ESC M**	Select character font/ MSR card read
36	**ESC R**	Specify an international character set
37	**ESC R S**	Stores international character set to NV memory
38	**ESC S**	Select standard mode
39	**ESC T**	Select print direction in page mode
40	**ESC U**	Specify unidirectional print mode
41	**ESC V**	Turn 90° clockwise rotation mode on/off
42	**ESC W**	Set print area in page mode
43	**ESC **	Set relative print position
44	**ESC a**	Set position alignment
45	**ESC d**	Print and feed n lines
46	**ESC e**	Print and reverse feed n lines
47	**ESC g 0**	Define macro (For logo)
48	**ESC g n**	Execute macro (For logo)
49	**ESC i**	Partial cut (one point left uncut)
50	**ESC m**	Partial cut (one point left uncut)
51	**ESC p**	Generate pulse
52	**ESC r**	Select print color
53	**ESC t**	Select character code table
54	**ESC u**	Transmit peripheral device status
55	**ESC v**	Transmit paper sensor status
56	**ESC {**	Turn upside-down print mode on/off
57	**FS !**	Set print mode for Kanji characters
58	**FS &**	Select Kanji character mode

No.	Command	Function
59	**FS -**	Turn underline mode on/off for Kanji characters
60	**FS .**	Cancel Kanji character mode
61	**FS 2**	Specify user-defined Kanji characters
62	**FS p**	Print NV bit image
63	**FS q**	Define NV bit image
64	**FS S**	Set Kanji character spacing
65	**FS W**	Turn quadruple-size mode on/off for Kanji characters
66	**FS ?**	Cancel user-defined Kanji characters
67	**GS !**	Select character size
68	**GS $**	Set absolute vertical print position in page mode
69	**GS (A**	Execute test print
70	**GS (F**	Set black mark control functions
71	**GS (N**	Select character color
72	**GS (k**	Specify and print the symbol
73	**GS ***	Define downloaded bit image
74	**GS /**	Print downloaded bit image
75	**GS :**	Start/end macro definition
76	**GS <**	Black mark initialization
77	**GS B**	Turn white/black reverse print mode on/off
78	**GS H**	Select print position of HRI characters
79	**GS I**	Transmit printer ID
80	**GS I b**	Transmit battery status
81	**GS L**	Set left margin
82	**GS T**	Set print position to the beginning of print line
83	**GS V**	Select cut mode and cut paper
84	**GS W**	Set print area width
85	**GS **	Set relative vertical print position in page mode
86	**GS ^**	Execute macro
87	**GS a**	Enable/disable Automatic Status Back (ASB)
88	**GS f**	Select font for HRI characters
89	**GS h**	Set bar code height
90	**GS k**	Print bar code
91	**GS r**	Transmit status
92	**GS v 0**	Print raster bit image
93	**GS w**	Set bar code width

4-1 Command Description Items

Command

Function: Command function outline

Code: Command format expressed in ASCII, hexadecimal, and decimal codes

Range: Argument value (Setting range) for the command

Default: Initial argument value for the command

Printers: Printer model supporting the command

Description: Detailed command function description

Remarks: Additional information about using the command

Differences: Variations depending on the printer model

4-2 Details of Control Commands

EOT

Function: **Transmit status**

Code:

ASCII	EOT	n
Hex	04	n
Decimal	4	n

Range: 1 ≤ n ≤ 4

Default: None

Printers: **All printer models**

Description: This command transmits the printer-related status specified by n as follows:

n	Function
1	Transmit printer status
2	Transmit off-line status
3	Transmit error status
4	Transmit paper roll sensor status

■ Printer transmits the following status

n=1: Printer status

Bit	Binary	Hex	Decimal	Status
0	0	00	0	Not used. Fixed to Off
1	1	02	2	Not used. Fixed to On
2	0	00	0	Drawer kick-out connector pin 3 is LOW
	1	04	4	Drawer kick-out connector pin 3 is HIGH
3	0	00	0	Online
	1	08	8	Offline
4	1	10	16	Not used. Fixed to On
5	0	00	0	Not used. Fixed to Off

Bit	Binary	Hex	Decimal	Status
6	0	00	0	Not used. Fixed to Off
7	0	00	0	Not used. Fixed to Off

n=2: Off-line status

Bit	Off/On	Hex	Decimal	Status
0	Off	00	0	Fixed
1	On	02	2	Fixed
2	Off	00	0	Cover is closed
	On	04	4	Cover is open
3	Off	00	0	Paper is not being fed by using the paper FEED button
	On	08	8	Paper is being fed by the paper FEED button
4	On	10	16	Fixed
5	Off	00	0	No paper-end stop
	On	20	32	Printing is being stopped
6	Off	00	0	No error
	On	40	64	Error has occurred
7	Off	00	0	Fixed

n=3: Error status

Bit	Binary	Hex	Decimal	Status
0	0	00	0	Not used. Fixed to Off
1	1	02	2	Not used. Fixed to On
2	0	00	0	No mechanical error
	1	04	4	Mechanical error occurred
3	0	00	0	No autocutter error
	1	08	8	Autocutter error occurred
4	1	10	16	Not used. Fixed to On
5	0	00	0	No unrecoverable error
	1	20	32	Unrecoverable error occurred
6	0	00	0	No auto-recoverable error
	1	40	64	Auto-recoverable error occurred
7	0	00	0	Not used. Fixed to Off

n=4: paper sensor status

Bit	Binary	Hex	Decimal	Status
0	0	00	0	Not used. Fixed to Off
1	1	02	2	Not used. Fixed to On
2,3	00	00	0	Paper near end sensor: paper adequate
	11	0C	12	Paper near end sensor: paper near end
4	1	10	16	Not used. Fixed to On
5,6	00	00	0	Paper end sensor: paper present
	11	60	96	Paper end sensor: paper not present
7	0	00	0	Not used. Fixed to Off

Remarks:

- This command can be executed in a real time mode using DLE.
- In a real time mode, the status is transmitted to the host upon being requested that can check the printer operational condition with it and takes appropriate measures accordingly.

Differences: Status not supported:

- **STP-103:**
  - n=1: Drawer kick-out connector
  - n=2: Printing stop, error
  - n=3: All of the status not supported
- **STP-131:**
  - n=2: Printing stop, error
  - n=3: Mechanical error, unrecoverable error, auto-recoverable error
- **SPP-R200:**
  - n=1: Drawer kick-out connector
  - n=2: Error
  - n=3: All of the status
  - n=4: Paper near end
- **SRP-270:**
  - n=2: Cover open/close
  - n=3: Autocutter error
- **SRP-280:**
  - n=2: Cover open/close
  - n=3: Autocutter error

■ **SRP-350, SRP-350N:**
n=3: Mechanical error, unrecoverable error, auto-recoverable error

■ **SRP-350plus, SRP-350plusN, SRP- 352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
n=3: Mechanical error, unrecoverable error, auto-recoverable error

Status supported:

■ **SRP-350plusV, SRP-350plusM:**
n=4: paper sensor status

Bit	Binary	Hex	Decimal	Status
0	0	00	0	Not used. Fixed to Off
1	1	02	2	Not used. Fixed to On
2	0	00	0	Status of BM sensor = “White”
	1	04	4	Status of BM sensor = “Black”
3	0	00	0	Paper near end sensor: paper adequate
	1	08	8	Paper near end sensor: paper near end
4	1	10	16	Not used. Fixed to On
5,6	00	00	0	Paper end sensor: paper present
	11	60	96	Paper end sensor: paper not present
7	0	00	0	Not used. Fixed to Off

ENQ

Function: **Request to printer**

Code:

ASCII	ENQ	n
Hex	05	n
Decimal	5	n

Range: n = 2

Default: None

Printers: **SRP-275, SRP-500**

Description: This command enables the printer to restore from an error state after clearing the receive and print buffers.

Remarks:

- This command can be executed in a real time mode with DLE preceding it.
- In a real time mode, upon receiving this command, the printer carries out the resume operation to get back normal by clearing error conditions.
- With a serial interface, the error state of the printer, limited to recoverable errors, can be removed by sending this command even if the printer is in offline or busy condition.
- With a parallel interface, this command is not performed in a busy condition because the printer can not receive the data from the host.

Differences: None

BS L A

Function: **Execute automatic calibration in label mode**

Code:

ASCII	BS	L	A
Hex	08	4C	41
Decimal	8	76	65

Range: None

Default: None

Printers: **SPP-R200**

Description: This command executes auto calibration in label mode.

Remarks:
- This command is effective only in the label mode.
- This command feeds 3 labels or 3 black marks to read the light intensity reflected from the liner or black mark and stores the optimal value into NV memory that is used to locate the label and black mark.
- The printer moves the printing position to the leading edge of the label or black mark using the optimal value stored.

Differences: None

BS L L

Function: **Select label mode**

Code:

ASCII	BS	L	L
Hex	08	4C	4C
Decimal	8	76	76

Range: None

Default: None

Printers: **SPP-R200**

Description:
- This commands selects label mode
  - The label mode must be set for printing on the label paper and black mark paper.

Remarks:
- This command is enabled in receipt mode.
- This command can activate the label mode even if the receipt mode is predefined by the memory switch(Msw8-5). However, since the mode specified by the memory switch(Msw8-5) is set to the default mode, the receipt mode becomes effective after the printer reset or power cycling is executed.
- The memory switch(Msw8-5) should be enabled to maintain the label mode after the printer reset or power cycling.
- Once the printer has entered the label mode, it is necessary to perform the procedures as follows for the proper operation:
  - Executing the automatic calibration to figure out the location of each label or black mark paper.
  - Readjusting the printing position by pressing paper Feed button or opening/closing the printer cover.

Differences: None

BS L R

Function: **Select receipt mode**

Code:

ASCII	BS	L	R
Hex	08	4C	52
Decimal	8	76	82

Range: None

Default: None

Printers: **SPP-R200**

Description:
- This command selects receipt mode
  - The receipt mode must be set for printing on the continuous roll paper

Remarks:
- This command is enabled only in label mode.
- This command can activate the receipt mode even if the label mode is predefined by the memory switch(Msw8-5). However, since the mode specified by the memory switch(Msw8-5) is set to the default mode, the label mode becomes effective after the printer reset or power cycling is executed.
- The memory switch(Msw8-5) should be disabled to maintain the receipt mode after the printer reset or power cycling.

Differences: None

BS ^ E

Function: **Set NV user memory area**

Code: None

Range: None

Default: None

Printers: **SPP-R200, SRP-275, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM, SRP-500**

Description: This command stores the customized values to the NV user memory area and uses them for the printer operation. The table below explains the functions available in this command. Executes commands related to the user setting mode by specifying the function code fn.

fn	Format	No.	Function
1	BS ^ E pL pH fn	1	Start the user setting mode
2	BS ^ E pL pH fn	2	End the user setting mode (Performs a soft reset)
3	BS ^ E pL pH fn [b18...b11]... [bk8...bk1]	3	Set value(s) for the memory switch
4	BS ^ E pL pH fn a	4	Transmit the settings of the memory switch to the host
11	BS ^ E pL pH fn d1...dk	11	Set the communication conditions for the serial interface
12	BS ^ E pL pH fn a	12	Transmit the communication conditions for the serial interface

Remarks:

- pL, pH is used to set the number of bytes following pH to (pL + pH x 256).
- The change in the items of the NV user memory is available only after entering the user setting mode.
- After completing the user setting mode (Function 2), the printer performs software reset to restore the initial settings in effect at power on. Receive and print buffers are cleared as well.
- Since frequent write operation by this command may deteriorate the performance of the NV memory, it is recommended to write to NV memory when the significant change in the setting is required.

■ While processing this command, the printer remains busy. Therefore the data transmission by the host is not available. The real time commands and ASB operations are not processed.

Differences:

■ **SPP-R200:**
Function (1,2,3,4,11, 12) are supported

■ **SRP-275:**
Function (1,2,3,4,11,12) are supported

■ **SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
Function (1,2,3,4,12) are supported

■ **SRP-500:**
Function (1,2,3,4) are supported

<Function 1> BS ^ E pL pH fn (fn=1)

Code:

ASCII	BS	^	E	pL	pH	fn
Hex	08	5E	45	pL	pH	fn
Decimal	8	94	69	pL	pH	fn

Range: (pL + pH x 256) = 1 (pL=1, pH=0)
fn=1

Default: None

Description: This command starts the user setting mode, enabling the printer to notify that the mode has changed as follows:
[Mode change feedback]

	Hexadecimal	**Decimal**	**Number of Data**
Header	37H	55	1 byte
Flag	20H	32	1 byte
NUL	00H	0	1 byte

Remarks:

- This command is effective only in standard mode, not in page mode.
- Upon entering the user mode setting mode by this command, the printer transmits “mode change feedback” to the host.
- The user setting mode should be enabled prior to processing <Function 2> through 12. Otherwise, those functions are ignored.
- After confirming “mode change feedback”, it is recommended to send the command to reconfigure the NV user memory.

Differences: None

<Function 2> BS ^ E pL pH fn d1 d2 d3 (fn=2)

Code:

ASCII	BS	^	E	pL	pH	fn
Hex	08	5E	45	pL	pH	fn
Decimal	8	94	69	pL	pH	fn

Range: (pL + pH x 256) = 1 (pL=1, pH=0)
fn=2

Default: None

Description: This command terminates the user setting mode and performs a software reset.

Remarks:
- This command activates setting items set in the user setting mode.
- All the setting items will be effective only after performing this command.
- After executing a software reset, the printer resumes the setting in effect at power on.

Differences: None

<Function 3> BS ^ E pL pH fn [b18...b11]...[bk8...bk1] (fn=3)

Code:

ASCII	BS	^	E	pL	fn	[b18...b11]... [bk8...bk1]
Hex	08	5E	45	pL	fn	[b18...b11]... [bk8...bk1]
Decimal	8	94	69	pL	fn	[b18...b11]... [bk8...bk1]

Range:

9≤ (pL + pH x 256) ≤ 65535
fn=3
b=48, 49, 50
1 ≤ k ≤ 10

Default: It varies depending on the printer model

Description:

■ This command changes all the Memory Switch(Msw) 1 through 8 to the value specified by b simultaneously as follows:

- When b=48, 49, the corresponding bit is set to Off and On respectively.
- When b=50, there is no change in the memory switch.

■ The setting items of the memory switch 1 are as follows:

Msw	Value			Function
	3	2	1	
1-1~3	48	48	48	Print density 130%
	48	48	49	Print density 120%
	48	49	48	Print density 110%
	48	49	49	Print density 150%
	49	48	48	Print density 100%
	49	48	49	Print density 140%
	49	49	48	Print density 90%
	49	49	49	Print density 80%

Msw	Value	Function
1-4	48	2 byte character mode not selected
	49	2 byte character mode selected
1-5	48	Print speed 80mm/s
	49	Print speed 50mm/s
1-6	48	Reserved

- The print density adjusts the darkness of characters to be printed.
- 2-byte character mode is selected to support for Chinese, Japanese, and Korean model.
- The printer supports 2 different printing speeds, 80 and 50mm/sec.
  Please be sure that the printing quality at higher speed may be worse than at the lower.

■ The setting items of the memory switch 2 are as follows:

Msw	Value	Function
2-1	48	Font selection: Font A
	49	Font selection: Font B
2-2	48	Autocutter Function: Partial Cutting
	49	Autocutter Function: Full Cutting

■ Code page selection using the memory switch 2-3 through 2-8.

Msw2-8	Msw2-7	Msw2-6	Msw2-5	Msw2-4	Msw2-3	Character Table
48	48	48	48	48	48	PC437
48	48	48	48	49	48	Katakana
48	48	48	49	48	48	PC850
48	48	48	49	49	48	PC860
48	48	49	48	48	48	PC863
48	48	49	48	49	48	PC865
48	48	49	49	48	48	WPC1252

Msw2-8	Msw2-7	Msw2-6	Msw2-5	Msw2-4	Msw2-3	Character Table
48	48	49	49	49	48	PC866
48	49	48	48	48	48	PC852
48	49	48	48	49	48	PC858
48	49	48	49	48	48	PC862
48	49	48	49	49	48	PC864
48	49	49	48	48	48	Thai42
48	49	49	48	49	48	WPC1253
48	49	49	49	48	48	WPC1254
48	49	49	49	49	48	WPC1257
49	48	48	48	48	48	Farsi
49	48	48	48	49	49	WPC1251
49	48	48	49	48	48	PC737
49	48	48	49	49	49	PC775
49	48	49	48	48	48	Thai 14
49	48	49	48	49	48	Hebrew old code
49	48	49	49	48	48	WPC1255
49	48	49	49	49	48	Thai 11
49	49	48	48	48	48	Thai 18
49	49	48	48	49	48	PC855
49	49	48	49	48	48	PC857
49	49	48	49	49	48	PC928
49	49	49	48	48	48	Thai 16
49	49	49	48	49	48	WPC1256
49	49	49	49	48	48	WPC1258
49	49	49	49	49	48	Not used

■ The setting items of the memory switch 3 are as follows:

Specify the 2 dimensional bar codes to be enabled using the memory switch 3-1 through 3-4.

Msw	Value	Function
3-1	48	PDF417 not selected
	49	PDF417 selected
3-2	48	DATAMATRIX not selected
	49	DATAMATRIX selected
3-3	48	MAXI CODE not selected
	49	MAXI CODE selected
3-4	48	QR CODE not selected
	49	QR CODE selected

- The printer supports 4 kinds of 2 dimensional bard codes such as PDF417, DATAMATRIX, MAXI code and QR code.
- The 2-D barcode to be used is activated by specifying the corresponding memory switch.
- The number of enabled 2D barcodes adversely affects the boot time of the printer. Therefore, it is strongly recommended to enable only the bard codes to be used.

■ The setting items of the memory switch 5 are as follows:

Specify the length of idle time before the printer enters the power-down mode.

- Range of idle time: 0 sec ≤ idle time ≤ 90 sec

  When memory switch value is 0, the power-down mode is not active

MSW5-8	MSW5-7	MSW5-6	MSW5-5	MSW5-4	MSW5-3	MSW5-2	MSW5-1	Value(Sec)
48	48	48	48	48	48	48	48	0
48	48	48	48	48	48	48	49	1
48	48	48	48	48	48	49	48	2
48	48	48	48	48	48	49	49	3
48	48	48	48	48	49	48	48	4
.	.	.	.	.	.	.	.	
.	.	.	.	.	.	.	.	
.	.	.	.	.	.	.	.	
48	49	48	49	49	48	49	48	90

■ The setting items of the memory switch 6 are as follows:
Set the standby time before the printer enters the power saving mode.
• Range of standby time: 10 sec ≤ standby time ≤ 255 sec
When memory switch value is 0, the power saving mode does not work.

MSW6-8	MSW6-7	MSW6-6	MSW6-5	MSW6-4	MSW6-3	MSW6-2	MSW6-1	Value
48	48	48	48	49	48	49	48	10
48	48	48	48	49	48	49	49	11
48	48	48	48	49	49	48	48	12
48	48	48	48	49	49	48	49	13
48	48	48	48	49	49	49	48	14
.	.	.	.	.	.	.	.	
.	.	.	.	.	.	.	.	
.	.	.	.	.	.	.	.	
49	49	49	49	49	49	49	49	255

■ The setting items of the memory switch 7 are as follows:
Specify the magnetic card read mode using the memory switch 7-5 through 7-8.

MSW	8	7	6	5	Function
7-5~8	48	48	48	49	Track 1/2/3 read mode command
	48	48	49	48	Track 1 read mode AUTO trigger
	48	48	49	49	Track 2 read mode AUTO trigger
	48	49	48	48	Track 3 read mode AUTO trigger
	48	49	48	49	Track 1/2 read mode AUTO trigger
	48	49	49	48	Track 2/3 read mode AUTO trigger
	48	49	49	49	Track 1/2/3 read mode AUTO trigger
	49	48	48	48	MSR not used

■ The setting items of the memory switch 8 are as follows:

- Either the character font A or B is selected.
- The beep is activated for the audible paper empty warning signal.
- The beep is activated for the audible low battery warning signal.
- The label printing is available by the setting.

Msw	Value	Function
8-1	48	Reserved
8-2	48	Font A
	49	Font B
8-3	48	Beep disabled for paper end
	49	Beep enabled for paper end
8-4	48	Beep enabled for low battery status
	49	Beep disabled for low battery status
8-5	48	Label mode disabled
	49	Label mode enabled
8-6	48	Reserved
8-7	48	Reserved
8-8	48	Reserved

■ The setting items of the memory switch 10 are as follows:
Specify the roll paper width to be used and color printing

Switch	Function	ON	OFF
1~4	Reserved	--	Fixed to OFF
5	Printing width	2 inch	3 inch
6	2Color support	Enable	Disable
7~8	Reserved	--	Fixed to OFF

Remarks: None

Differences: ■ **SPP-R200:**

- The memory switch (1,2, 3, 5, 6, 7, 8) are available.
- Font selection (Msw 2-1) and autocutter function(Msw 2-2) of the memory switch 2 are not supported.

■ **SRP-275:**

- The memory switch (2, 8) are available.
- The following items of the memory switch 2 are not supported.
  - Font selection (Msw 2-1), autocutter function (Msw 2-2), code page(PC855, Thai 16, WPC1256)
- The setting items of the memory switch 8 is as follows:

Msw	Value	Function
8-1	48	Print normally
	49	Print upside-down
8-2	48	Font B
	49	Font A
8-3	48	Beeper enabled for paper end
	49	Beeper disabled for paper end
8-4	48	Reserved
8-5	48	The status of the paper empty is transmitted for the cover open
	49	The status of the cover open is transmitted for the cover open
8-6	48	Reserved
8-7	48	Release the receive buffer full when the remaining capacity of the receive buffer reaches 640 bytes
	49	Release the receive buffer full when the remaining capacity of the receive buffer reaches 522 bytes
8-8	48	Printer cover open error during printing recovers automatically
	49	Printer cover open error during printing recovers by the command

■ **SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**

- The memory switch (1,2,9,10) are available.
- The memory switch (3~8) are not supported.

Msw	Value	Function
1-1~3	48	Reserved
1-4	48	Auto generation of pulse to internal beep not selected
	49	Auto generation of pulse to internal beep selected
1-5~6	48	Reserved

Msw	Value	Function
9-1	48	Single byte charater code selected
	49	Double byte character code selected
9-3	48	Reserved

Msw	Value	Function
10-1	48	Auto generation of pulse to cashdrawer not selected
	49	Auto generation of pulse to cashdrawer selected
10-2~4	48	Reserved
10-5	48	3-inch printing width
	49	2-inch printing width
10-6	48	1-color printing
	49	2-color printing
10-7~8	48	Reserved

■ **SRP-500:**

- The memory switch 1 is available.
- The setting items of the memory switch 1 is as follows:

Msw 1-6	Msw 1-5	Msw 1-4	Msw1-3	Msw 1-2	Msw 1-1	Character Table
48	48	48	48	48	48	PC437: U.S.A
48	48	48	48	49	48	PC850: Multilingual
48	48	48	48	49	49	PC860: Portuguese
48	48	48	49	48	48	PC863: Canadian-French
48	48	48	49	48	49	PC865: Nordic
48	49	48	48	48	48	WPC1252: Latin I
48	49	48	48	48	49	PC866: Cyrillic #2
48	49	48	48	49	48	PC852: Latin II)
48	49	48	48	49	48	PC858: Euro
48	49	48	48	48	49	PC862: Hebrew DOS code
48	49	48	48	48	49	PC864: Arabic
48	49	48	49	49	49	Thai 42
48	49	49	48	48	48	WPC1253: Greek
48	49	49	48	49	48	WPC1257: Baltic
48	49	49	48	49	49	Farsi
48	49	49	48	48	49	PC737: Greek
48	49	49	49	49	49	Thai 14
49	48	48	48	49	48	Thai 11
49	48	48	48	49	49	Thai 18
49	48	48	49	49	48	PC928: Greek

<Function 4> BS ^ E pL pH fn a (fn=4)

Code:

ASCII	BS	^	E	pL	pH	fn	a
Hex	08	5E	45	02	00	04	a
Decimal	8	94	69	2	0	4	a

Range:

(pL + pH x 256) = 2 (pL=2, pH=0)
fn=4

- **SRP-275:**
  a=2, 8
- **SPP-R200:**
  a=1, 2, 3, 5, 6, 7, 8
- **SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
  a=1,2,9,10
- **SRP-500:**
  a=1

Default:

None

Description:

This command transmits the setting value of the memory switch corresponding to a.

	Hexadecimal	Decimal	Amount of Data
Header	37H	55	1 byte
Identifier	21H	33	1 byte
Setting value	30H or 31H	48 or 49	8 bytes
NUL	00H	0	1 byte

- The setting value is sent from bit 8 to bit 1, consisting of 8 bytes in total.
  - Off: Hexadecimal = 30H / Decimal = 48
  - On: Hexadecimal = 31H / Decimal = 49

Remarks:

None

Differences:

None

<Function 11>BS ^ E pL pH fn a d1….dk (fn=11)

Code:

ASCII	BS	^	E	pL	pH	fn	[d11...d16][d12][d13][d14]
Hex	08	5E	45	pL	pH	0B	[d11...d16][d12][d13][d14]
Decimal	8	94	69	pL	pH	11	[d11...d16][d12][d13][d14]

Range:

8 ≤ (pL + pH x 256) ≤ 10 (8 ≤ pL ≤ 10, 0 ≤ pH ≤ 255)
fn=11
48 ≤ d ≤ 57

Default:

Parity: no parity, Flow control: DTR/DSR, Data length: 8 bits

- **SPP-R200:**
  Baud rate: 115200bps
- **SRP-275:**
  Baud rate: 9600bps

Description:

This command specifies the configuration items of the serial interface such as the baud rate, parity, flow control, data length, collectively.

Setting Order	Configuration item
1	Transmission speed
2	Parity
3	Flow control
4	Data length

The array of parameters change according to pL, pH as follows:

When (pL+pH x256) =10:
d11~d61: Baud rate value
d12: Parity setting value
d13: Flow control setting value
d14: Data length setting value

When (pL+pH x256) =9:
d11~d51: Baud rate value
d12: Parity setting value
d13: Flow control setting value
d14: Data length setting value

When (pL+pH x256) =8:
d11~d41: Baud rate value
d12: Parity setting value
d13: Flow control setting value
d14: Data length setting value

For instance, when defining 19200 bps, (pL = 9, pH=0) and ASCII converted character data(Hexadecimal = 31H,39H,320H,30H,30H//Decimal= 49, 57, 50, 48, 48) of 19200 should be sent.

Baud rate is specified as follows: (4 ≤ k ≤ 6)

d11~dk1	Function
“115200”	Baud rate 115200
“57600”	Baud rate 57600
“38400”	Baud rate 38400
“19200”	Baud rate 19200
“9600”	Baud rate 9600
“4800”	Baud rate 4800
“2400”	Baud rate 2400

Parity is specified by d12 as follows:

d12	Function
48	Select no parity
49	Select odd parity
50	Select even parity

Flow control is specified by d13 as follows:

d13	Function
48	Select flow control DTR/DSR
49	Select flow control XON/XOFF

Data Length(a=4) is specified by d14 as follows:

d14	Function
55	Select 7bits length
56	Select 8bits length

Remarks:

- The change of settings of serial interface is available by adjusting the corresponding DIP switch that is recommended for setting of serial interface.
- To enable the settings by this command, it is first required to adjust the DIP switch that activates the serial interface configuration set by the memory switch.

Differences:

Buad rate range available by the printer model:

- **STP-103, STP-131, SPP-R200, SRP-350plus, SRP-352plus, SRP-350plusN, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
  2400 – 115200 bps
- **SRP-270, SRP-275, SRP-280, SRP-500:**
  2400 – 19200 bps
- **SRP-350, SRP-350N:**
  2400 – 57600 bps
- **SPP-R200, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
  The serial interface configuration is specified only by setting the memory switch.

<Function 12> BS ^ E pL pH fn a (fn=12)

Code:

ASCII	BS	^	E	pL	pH	fn	a
Hex	08	5E	45	pL	pH	fn	a
Decimal	8	94	69	pL	pH	fn	a

Range: (pL + pH x 256) = 2 (pL=2, pH=0)
fn=12, 1 ≤ a ≤ 4

Default: None

Description: ■ This command transmits the communication conditions of the serial interface according to a as follows:

a	Communication Condition
1	Baud rate
2	Parity
3	Flow control
4	Data length

■ The data format to be transmitted is as follows:

	Hexadecimal	Decimal	Amount of Data
Header	37H	55	1 byte
Identifier	33H	39	1 byte
Communication condition(a)	31H - 34H	49 - 52	1 byte
Separator	1FH	31	1 byte
Setting value	30H - 39H	48 - 57	1 - 6 bytes
NUL	00H	0	1 byte

Communication condition is define by “a” and setting value defined as shown in the following.

■ Configuration of the setting value

• When the baud rate (a=1) is specified:

Baud rate (bps)	d1	d2	d3	d4	d5	d6
2400	50	52	48	48	--	--
4800	52	56	48	48	--	--
9600	57	54	48	48	--	--
19200	49	57	50	48	48	--
38400	51	56	52	48	48	--
57600	53	55	54	48	48	--
115200	49	49	53	50	48	48

• When the parity setting (a=2) is specified:

d1	Parity
48	No parity
49	Odd parity
50	Even parity

• When the flow control setting (a=3) is specified:

d1	Flow control
48	DTR / DSR (Fixed)
49	XON / XOFF

• When the data length setting (a=4) is specified:

d1	Data length
55	7 bits
56	8 bits

Remarks: None

Differences: None

BS ^ L, BS ^ 7

Function: **Select graphics data**

Code:

ASCII	BS	^	L	pL	pH	[parameter]
Hex	08	5E	4C	pL	pH	[parameter]
Decimal	8	94	76	pL	pH	[parameter]

ASCII	BS	^	7	p1	p2	p3	p4	fn	[parameter]
Hex	08	5E	37	p1	p2	p3	p4	fn	[parameter]
Decimal	8	94	55	p1	p2	p3	p4	fn	[parameter]

Range: None

Default: None

Printers: **SPP-R200, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM**

Description: This command processes graphics data according to the function code (fn).

fn	Function No.	Format	Function
2, 50	50	BS ^ L pL pH fn	Prints the graphics data in the print buffer
65	65	BS ^ L pL pH fn	Deletes all NV graphics data
66	66	BS ^ L pL pH fn c	Deletes the specified NV graphics data
67	67	BS ^ 7 p1 p2 p3 p4 fn N {b xL xH yL yH [c d1...dk]1}...{ b xL xH yL yH [c d1 dk]N}	Defines the graphics data in the non-volatile memory
69	69	BS ^ L pL pH fn c x y	Prints the specified NV graphics data
112	112	BS ^ L pL pH fn a bx by c xL xH yL yH d1...dk	Stores the graphics data in the print buffer memory

Remarks:

- This command is adapted to print image data.
- pL, pH specifies the number of bytes following pH using (pL + pH x 256).

■ Since frequent writing operation could cause the damage to the NV memory, it is recommended to write only when being required.
■ While storing data by this command, the printer is in BUSY state where receiving of data is not available. Therefore, it is not recommended to send data during this process.
■ The real time commands and ASB operations are not allowed during NV memory operation process.

Differences: None

<Function 50> BS ^ L pL pH fn (fn=2, 50)

Code:

ASCII	BS	^	L	pL	pH	fn
Hex	08	5E	4C	pL	pH	fn
Decimal	8	94	76	pL	pH	fn

Range: (pL + pH x 256) = 1 (pL=2, pH=0)
m=48, fn=2, 50

Default: None

Description: This command prints the graphics data defined by the process of Function 112.

Remarks:
- The graphics data stored in the printer buffer is printed.
- This command is available in standard mode, not in page mode.
- The graphics data is defined by Function 112.
- The required amount of line feed pitch is used for printing graphics data, regardless of the existing setting value of the pitch.

Differences:
- **SPP-R200:**
  This command is available in both standard and page modes.

<Function 65> BS ^ L pL pH fn (fn=65)

Code:

ASCII	BS	^	L	pL	pH	fn
Hex	08	5E	4C	pL	pH	fn
Decimal	8	94	76	pL	pH	fn

Range: (pL + pH x 256) = 1 (pL=1, pH=0)
fn=65

Default: None

Description: This command removes all defined NV graphics data.

Remarks:
- The graphics data is define by Function 67 into the NV graphics memory with the sector dedicated for storing NV graphics data.

Differences: None

<Function 66> BS ^ L pL pH fn c (fn=66)

Code:

ASCII	BS	^	L	pL	pH	fn	N
Hex	08	5E	4C	pL	pH	fn	N
Decimal	8	94	76	pL	pH	fn	N

Range:

(pL + pH x 256) = 2 (pL=2, pH=0)
fn=66
0 ≤ N ≤ 77

Default:

None

Description:

This command deletes the NV graphics data corresponding to N.

Remarks:

- The graphics data is define by Function 67.
- N is given automatically to each of the graphics data groups to be stored into the NV graphics memory in the order of download.

Differences:

None

<Function 67> BS ^ 7 p1 p2 p3 p4 fn N {b xL xH yL yH [c d1...dk]1}...{b xL xH yL yH [c d1...dk]N}(fn=67)

Code:

ASCII	BS	^	7	P1 p2 p3 p4 fn N {b xL xH yL yH [c d1...dk]1}...{b xL xH yL yH [c d1...dk]N}
Hex	08	5E	37	P1 p2 p3 p4 fn N {b xL xH yL yH [c d1...dk]1}...{b xL xH yL yH [c d1...dk]N}
Decimal	8	94	55	P1 p2 p3 p4 fn N {b xL xH yL yH [c d1...dk]1}...{b xL xH yL yH [c d1...dk]N}

Range:

$3 \le (p1 + p2 \times 256 + p3 \times 65536 + p4 \times 16777216) \le 262144$
$(0 \le p1 \le 255, 0 \le p2 \le 255, 0 \le p3 \le 255, 0 \le p4 \le 255)$
fn=67
$1 \le c \le 255$
$1 \le (xL + xH \times 256) \le 1024$
$1 \le (yL + yH \times 256) \le 1200$
$0 \le d \le 255$
$k = (\text{int} ((xL + xH \times 256) + 7) / 8) \times (yL + yH \times 256)$
$0 \le N \le 77$

■ **SPP-R200:**
b =1(Single color printing), c=49(when monochrome paper used)
■ **SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
b=1, 2(2-color printing), c=49, 50(when 2-color paper used)

Default: None

Description:

■ This command defines NV graphics data as N assigned in the order of download.
■ The following parameters are used to define the raster graphics data.
- b specifies the number of colors for the defined data.
- N specifies the number of NV graphics data groups to be defined.
- xL and xH specify the number of dots in horizontal direction to (xL + xH x 256).
- yL and yH specify the number of dots in horizontal direction to (yL + yH x 256) dots.
- c specifies the color of the defined data.

c	Defined data color
49	Color 1
50	Color 2

Remarks:

- Color 1 means black, and Color 2 red that is available for 2-color paper.
- If new NV graphics data is saved or the existing data is modified, all of the existing data in NV graphics memory are flushed and updated using this command. The rest of NV graphics data groups having no change should be redefined along with the new group stored.
- When NV graphics data groups are saved, each of the groups is allocated with N in the order of download.

Differences: Total capacity of the NV graphics memory:

- **SPP-R200:**
  The total capacity of the NV graphics memory is 256K bytes.
- **SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
  256K bytes of NV memory is reserved for each of mono color and 2-color graphics data. Therefore, the total capacity of the NV graphics memory is 512K bytes.

<Function 69> BS ^ L pL pH fn c x y (fn=69)

Code:

ASCII	BS	^	L	pL	pH	fn	N	x	y
Hex	08	5E	4C	pL	pH	fn	N	x	y
Decimal	8	94	76	pL	pH	fn	N	x	y

Range:

(pL + pH x 256) = 4 (pL=4, pH=0)
fn=69
0 ≤ N ≤ 77
x=1, 2
y=1, 2

Default: None

Description:

■ This command prints the NV graphics data defined by N.
- The graphics data is enlarged by x and y in the horizontal and vertical directions respectively.

Remarks:

■ This command prints the NV graphics data defined by Function 67.
■ NV graphic data corresponding to N is only printed.
■ In page mode, this command is not effective.
■ NV graphics data beyond the print area for one line is not printed.

Differences:

■ **SPP-R200:**
This command is effective both in standard and page modes.

<Function 112> BS ^ L pL pH fn a bx by c xL xH yL yH d1...dk (fn=112)

Code:

ASCII	BS	^	L	pL pH fn a bx by c xL xH yL yH d1...dk
Hex	08	5E	4C	pL pH fn a bx by c xL xH yL yH d1...dk
Decimal	8	94	76	pL pH fn a bx by c xL xH yL yH d1...dk

Range:

11 ≤ (pL + pH x 256) ≤ 65535 (0 ≤ pL ≤ 255, 0 ≤ pH ≤ 255)
fn=112, a=48
bx=1, 2
by=1, 2
1 ≤ (xL + xH x 256) ≤ 1024
1 ≤ (yL + yH x 256) ≤ 1200 (when by = 1)
k = (int ((xL + xH x 256) + 7) / 8) x (yL + yH x 256)

■ **SPP-R200:**
c=49(when monochrome paper used)
■ **SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
c=49, 50(when 2-color paper used)

Default: None

Description:

■ This command stores the raster graphics data in the print buffer, enlarged by bx and by in the horizontal and vertical directions.
- xL, xH specifies the raster graphics data in the horizontal direction as (xL + xH x 256) dots.
- yL, yH specifies the raster graphics data in the vertical direction to (yL + yH x 256) dots.
- d denotes the stored data(raster format).
- k denotes the number of the graphics data.
- c specifies the color of the defined data.

c	Defined data color
49	Color 1
50	Color 2

- Color 1 means black, and Color 2 red or blue that is available for 2-color paper.

Remarks:

- The graphics data is stored in the printer buffer directly.
- NV graphics data beyond the print area for one line is not printed.
- Real time command is not effective during processing of this command.

Differences: None

HT

Function: **Horizontal tab**

Code:

ASCII	HT
Hex	09
Decimal	9

Range: None

Default: None

Printers: **All printer models**

Description: This command moves the print position to the next horizontal tab position. If the next horizontal tab position is not specified, this command will be void.

Remarks:
- The horizontal tab position is set by <ESC> D.
- With the underline mode turned on, the underline printing is not applied to the tab space created by this command.

Differences: None

LF

Function: **Print and line feed**

Code:

ASCII	LF
Hex	0A
Decimal	10

Range: None

Default: None

Printers: **All printer models**

Description: This command prints the data in the print buffer and feeds one line based on the current set line spacing in standard mode.

Remarks: ■ In page mode, the printer does not perform actual printing, but moving only the print position to the next line.

Differences: None

FF

Function: **Form feed (in page mode)**

Code:

ASCII	FF
Hex	0C
Decimal	12

Range: None

Default: None

Printers: **SPP-R200, SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM**

Description: This commands prints all data collected in the printer buffer In page mode. After completion of printing, the printer is returned to standard mode.

Remarks:
- The printer is returned to standard mode after completion of printing.
- After being printed, all of the existing data in the printer buffer is evacuated and the print position changes to the beginning of the line.
- This command works in page mode enabled by ESC L or FS L.

Differences:
- **SPP-R200:**
  After completion of printing, the printer does not clear the printer buffer and the print position moves to the beginning of the line.
- **SRP-350plusV, SRP-350plusM:**
  - This command is only effective in standard mode.
  - If the receive buffer is not empty, the paper is fed to the next print starting position after completion of printing all data in the receive buffer.
  - If the paper is positioned at the print starting position, this command is ignored, not performing actual paper feeding operation.

CR

Function: **Print and carriage return**

Code:

ASCII	CR
Hex	0D
Decimal	13

Range: None

Default: None

Printers: **All printer models**

Description: This command prints the data. With auto line feed enabled, it performs printing and one line feeding same as LF.

Remarks:
- Auto line feed is only enabled with a parallel interface using the DIP switch.

Differences:
- **SRP-275:**
  Auto line feed is turned on by setting DIP S/W 2-1
- **SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
  Auto line feed is turned on by setting DIP S/W 1-1

DLE

Function: **Set real-time command mode**

Code:

ASCII	DLE
Hex	10
Decimal	16

Range: None

Default: None

Printers: **All printer models**

Description: This command enables commands to be operable in real-time.

Remarks:
- A single command following this command is regarded as a real time command.
- The real time command is stored into the receive buffer and executed with higher priority than other commands.
- If this command is processed as a parameter of the other command, the data following this command might bring about the unwanted result.
- The commands that are allowed to be executed in real time mode vary depending on the printer model.

Differences: Commands that can be executed in real time mode:

- **STP-103, STP-131:**
  EOT, DC4, GS I , GS a, GS r
- **SRP-270, SRP-280:**
  EOT, DC4, GS I,GS a
- **SPP-R200:**
  EOT, GS r, GS I, GS I b
- **SRP-275:**
  EOT, ENQ, DC4, GS I,GS a, GS r

■ **SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
EOT,DC4,GS I,GS a

■ **SRP-500:**
EOT, ENQ, GS I , GS a, GS r,

CAN

Function: **Cancel the print data in page mode**

Code:

ASCII	CAN
Hex	18
Decimal	24

Range: None

Default: None

Printers: **SPP-R200, SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM**

Description: This command clears the receive buffer and print buffers in page mode.

Remarks: ■ This command is effective only in page mode that is set by ESC L.

Differences: None

DC4

Function: **Generate pulse**

Code:

ASCII	DC4	n	m	t
Hex	14	n	m	t
Decimal	20	n	m	t

Range: n = 1, m=0,1, 1 ≤ t ≤ 8

Default: None

Printers: **STP-103, STP-131, SRP-270, SRP-275, SRP-280, SRP-350, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM**

Description:

■ This command generates the drive pulse to connector pin m with pulse width defined by t as following:
- Drawer kick-out connector pin 2 is selected with m=0 while pin 5 chosen for m=1.
- Pulse ON time is [t x100 ms] and OFF time [t x100 ms]

Remarks:

■ This command can be executed in a real time mode by placing DLE prior to it.

■ In a real time mode, upon receiving this command, the printer outputs the drive pulse to the specified connector pin.

Differences: None

ESC FF

Function: **Print data in page mode**

Code:

ASCII	ESC	FF
Hex	1B	0C
Decimal	27	12

Range: None

Default: None

Printers: **SPP-R200**

Description: This command prints the data in the print buffer collectively in page mode.

Remarks:
- This command is effective only in page mode that is selectd by ESC L.
- After printing, the data in the print buffer and setting values are not cleared.
- The printer can print the data in the print buffer repeatedly using this command.
- The printer returns to standard mode by ESC S or ESC @.

Differences: None

ESC SP

Function: **Set the character right space**

Code:

ASCII	ESC	SP	n
Hex	1B	20	n
Decimal	27	32	n

Range: 0 ≤ n ≤ 255

Default: n=0

Printers: **All printer models**

Description:
- This command sets the size of space to right of character.
  - Right space = n × [horizontal motion units].

Remarks:
- In a double width mode, the right space will be doubled.
- Horizontal motion unit varies depending the printer model.

Differences: Horizontal motion unit:

- **SRP-270, SRP-275, SRP-280:**
  0.159mm(1/160 inch)
- **STP-131, SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-350plusV, SRP-350plusM:**
  0.141mm(1/180 inch)
- **STP-103, SPP-R200, SRP-352plus, SRP-352plusN:**
  0.125mm(1/203 inch)
- **SRP-500:**
  0.122mm(1/208 inch)

ESC !

Function: **Set print mode**

Code:

ASCII	ESC	!	n
Hex	1B	21	n
Decimal	27	33	n

Range: 0 ≤ n ≤ 255

Default: n=0

Printers: **All printer models**

Description: This command selects print mode(s) with bits having following meanings.

Bit	Off/On	Hex	Decimal	Function
0	Off	00	0	Character font A selected
	On	01	1	Character font B selected
1,2	Off	00	0	Reserved
3	Off	00	0	Emphasized mode not selected
	On	08	8	Emphasized mode selected
4	Off	00	0	Double-height mode not selected
	On	10	16	Double-height mode selected
5	Off	00	0	Double-width mode not selected
	On	20	32	Double-width mode selected
6	Off	00	0	Reserved
7	Off	00	0	Underline mode not selected

Remarks:

- As alternative to this command, ESC M, ESC E and ESC – can be used for the selection for character font, emphasized mode and underline mode respectively.
- The entire character print width is underlined, but the space skipped by HT is not.
- If both double width and double height are selected, the characters will be quadrupled.

Differences: Character configuration(Font A, Font B)

■ **STP-103, STP-131, SPP-R200, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
Font A(12 × 24), Font B(9 x 24)

■ **SRP-270, SRP-275, SRP-280:**
Font A(9 × 9), Font B(7 x 9)

■ **SRP-350, SRP-350N:**
Font A(12 × 24), Font B(9 x 17)

■ **SRP-500:**
Font A(14 × 12), Font B(12 x 12)

ESC $

Function: **Set absolute print position**

Code:

ASCII	ESC	$	nL	nH
Hex	1B	24	nL	nH
Decimal	27	36	nL	nH

Range: 0 ≤ (nL + nH x 256) ≤ 65535 (0 ≤ nH ≤ 255, 0 ≤ nL ≤ 255)

Default: None

Printers: **STP-103, STP-131, SPP-R200, SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM**

Description: This command specifies the next print starting position in reference to the left edge of the print area. The printing start position is calculated using (nL + nH x 256) x (vertical or horizontal motion units).

Remarks:
- Any setting values that go beyond the printable area is ignored.
- In standard mode, the horizontal motion unit is used for the calculation.
- In page mode, the horizontal motion unit is applied when printing start poison is defined to the upper right or lower right of print area using ESC T, otherwise, the vertical motion unit is used.

Differences: Horizontal motion unit:

- **STP-131, SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-350plusV, SRP-350plusM:**
  0.141mm(1/180 inch)
- **STP-103, SPP-R200, SRP-352plus, SRP-352plusN:**
  0.125mm(1/203 inch)

ESC %

Function: **Select/cancel user-defined character set**

Code:

ASCII	ESC	%	n
Hex	1B	25	n
Decimal	27	37	n

Range: 0 ≤ n ≤ 255

Default: n = 0

Printers: **All printer models**

Description:
- This command selects/deselects user-defined character set that is downloaded by user. To make it valid, the least significant bit should be defined like following.
  - When n=0, the user-defined character set is deselected.
  - When n=1, the user-defined character set is selected.

Remarks:
- The resident character set is enabled and used right after canceling the user defined character set.

Differences: None

ESC &

Function: **Define user-defined character set**

Code:

ASCII	ESC	&	y c1 c2 [x1 d1 ... d(y × x1)]... [xk d1 ... d(y × xk)]
Hex	1B	26	y c1 c2 [x1 d1 ... d(y × x1)]... [xk d1 ... d(y × xk)]
Decimal	27	38	y c1 c2 [x1 d1 ... d(y × x1)]... [xk d1 ... d(y × xk)]

Range:

- **SRP-270, SRP-275, SRP-280:**
  y = 2
  32 ≤ c1 ≤ c2 ≤ 126
  0 ≤ x ≤ 12 (Font A)
  0 ≤ x ≤ 10 (Font B)
  0 ≤ d ≤ 255
  k = c2 – c1 + 1
- **STP-103, STP-131, SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
  y = 3
  32 ≤ c1 ≤ c2 ≤ 126
  0 ≤ x ≤ 12 (Font A)
  0 ≤ x ≤ 9 (Font B)
  0 ≤ d ≤ 255
  k = c2 – c1 + 1
- **SRP-500:**
  y = 2
  32 ≤ c1 ≤ c2 ≤ 126
  0 ≤ x ≤ 14 (Font A)
  0 ≤ x ≤ 12 (Font B)
  0 ≤ d ≤ 255
  k = c2 – c1 + 1

Default: None

Printers: All printer models except for **SPP-R200**

Description:

■ This command defines user-defined characters for character codes in a designated range from the start character code, c1 to the end character code, c2.

• y denotes the number of bytes in the vertical direction, x the number of dots in the horizontal direction, and d the dot data for the user-defined characters.

Remarks:

■ Alphanumeric characters (20H (decimal 32) to 7EH (decimal 126)) are definable.

■ Once user defined characters are defined, they remain available until they are redefined; ESC ? or ESC @ is executed; the printer is reset.

■ The following shows the relationship between the definition data and printing result with downloaded character consisting of 9x7 dots.

d1	d3	d5	d7	d9	d11	d13	MSB LSB
d2	d4	d6	d8	d10	d12	d14	MSB LSB

Differences: Character configuration(Font A, Font B)

■ **SRP-270, SRP-275, SRP-280:**
Font A(9 × 9), Font B(7 x 9)

■ **STP-103, STP-131, SPP-R200, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
Font A(12 × 24), Font B(9 x 24)

■ **SRP-350, SRP-350N:**
Font A(12 × 24), Font B(9 x 17)

■ **SRP-500:**
Font A(14 × 12), Font B(12 x 12)

ESC *

Function: **Specify bit image mode**

Code:

ASCII	ESC	*	m	nL	nH	d1...dk
Hex	1B	2A	m	nL	nH	d1...dk
Decimal	27	42	m	nL	nH	d1...dk

Range:

■ **SPP-R200, STP-131, SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**

m = 0, 1, 32, 33

0 ≤ nL ≤ 255

0 ≤ nH ≤ 3

0 ≤ d ≤ 255

k = nL + nH × 256 [in case of m = 0, 1]

k = (nL + nH × 256) × 3 [in case of m = 32, 33]

■ **SRP-270, SRP-275, SRP-280, SRP-500:**

m = 0, 1

0 ≤ n_L ≤ 255

0 ≤ n_H ≤ 3

0 ≤ d ≤ 255

k = n_L + n_H x 255

Default: None

Printers: **All printer models**

Description: ■ This command specifies the bit image for the mode m as to the number of dots specified by nL and nH.

- d specifies the bit image data with 1 for printed data and 0 for not printed.
- k denotes the number of horizontal dots.

DPI : Dots per Inch (25.4mm)

m	Mode	Number of dots in vertical direction	Vertical dot density (DPI)	Horizontal dot density (DPI)	Number of bytes (k)
0	8-dot single-density	8	203/3	203/2	nL + nH x 256
1	8-dot double-density	8	203/3	203	nL + nH x 256
32	24-dot single-density	24	203	203/2	(nL + nH x 256) x 3
33	24-dot double-density	24	203	203	(nL + nH x 256) x 3

Remarks:

- If the bit image data being entered is beyond the number of dots to be printed, the surplus will be discarded.
- If the value of m is beyond the conditions, the subsequent data after m will be treated as normal data.

Differences:

■ **STP-131, SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-350plusV, SRP-350plusM:**

DPI : Dots per Inch (25.4mm)

m	Mode	Number of dots in vertical direction	Vertical dot density (DPI)	Horizontal dot density (DPI)	Number of bytes (k)
0	8-dot single-density	8	60	90	nL + nH x 256
1	8-dot double-density	8	60	180	nL + nH x 256
32	24-dot single-density	24	180	90	(nL + nH x 256) x 3
33	24-dot double-density	24	180	180	(nL + nH x 256) x 3

■ **SRP-270, SRP-275, SRP-280:**

DPI : Dots per Inch (25.4mm)

m	Mode	Number of dots in vertical direction	Vertical dot density (DPI)	Horizontal dot density (DPI)	Number of bytes (k)
0	8-dot single-density	8	72	80	nL + nH x 256
1	8-dot double-density	8	72	160	nL + nH x 256

■ **SRP-500:**

DPI : Dots per Inch (25.4mm)

m	Mode	Number of dots in vertical direction	Vertical dot density(DPI)	Horizontal dot density (DPI)	Number of bytes (k)
0	8-dot single-density	8	96	104	nL + nH x 256
1	8-dot double-density	8	96	208	nL + nH x 256

ESC –

Function: **Turn underline mode on/off**

Code:

ASCII	ESC	-	n
Hex	1B	2D	n
Decimal	27	45	n

Range: 0 ≤ n ≤ 2, 48 ≤ n ≤ 50

■ **SRP-270, SRP-280:**
0 ≤ n ≤ 1, 48 ≤ n ≤ 49

Default: n=0

Printers: **All printer models**

Description: ■ This command enables the print data following it to be printer out underlined.
• The underline mode varied depending on the following values of n:

n	Function
0,48	Turns off underline mode
1,49	Turns on underline mode, set at 1-dot thick
2,50	Turns on underline mode, set at 2-dot thick

Remarks: ■ The spaces generated by horizontal tab are not underlined.
■ Using bit 7 of ESC !, the underline mode can be activated/deactivated as well.

Differences: None

ESC 2

Function: **Select default line spacing**

Code:

ASCII	ESC	2
Hex	1B	32
Decimal	27	50

Range: None

Default: None

Printers: **All printer models**

Description: This command sets the default line spacing The default line spacing is approximately 3.75 mm, which is equivalent to 30 dots.

Remarks:

- The line spacing can be set independently in standard mode and in page mode.
- The setting of this command remains effective until ESC !, ESC @, printer reset or power cycling is executed.

Differences: Default line spacing:

- **STP-103, SPP-R200, SRP-352plus, SRP-352plusN:**
  3.75 mm(30 dots)
- **SRP-270, SRP-275, SRP-280:**
  4.23 mm(12 dots)
- **STP-131, SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-350plusV, SRP-350plusM:**
  4.23 mm (30 dots)
- **SRP-500:**
  4.23 mm(16 dots)

ESC 3

Function: **Set line spacing**

Code:

ASCII	ESC	3	n
Hex	1B	33	n
Decimal	27	51	n

Range: 0 ≤ n ≤ 255

Default: Corresponding to the default line spacing defined by ESC 2

Printers: **All printer models**

Description:
- This command sets the line spacing using a following rule.
  - Line spacing = n x (vertical or horizontal motion units)

Remarks:
- With standard mode selected, the vertical motion unit is used.
- In page mode, the horizontal motion unit is applied when printing start poison is defined to the upper right or lower right of print area using ESC T, otherwise, the vertical motion unit is used.
- The line spacing is settable independently for each of standard and page modes.

Differences: Vertical or horizontal motion unit and maximum line spacing settable:

Model	Vertical unit	Horizontal unit	Max line spacing
STP-103 **SRP-352plus** **SRP-352plusN**	0.0625mm (1/406 inches)	0.125mm (1/203 inches)	15.937mm
SPP-R200	0.125mm (1/203 inches)	0.125mm (1/203 inches)	31.875mm
SRP-270 **SRP-275** **SRP-280**	0.176mm (1/144 inches)	0.176mm (1/144 inches)	44.98mm
STP-131 **SRP-350** **SRP-350N** **SRP-350plus** **SRP-350plusN** **SRP-350plusV** **SRP-350plusM**	0.0705mm (1/360 inch)	0.141mm (1/180 inch)	17.98mm
SRP-500	0.132 mm (1/192 inches)	0.122mm (1/208 inches)	33.66mm

ESC <

Function: **Return home**

Code:

ASCII	ESC	<
Hex	1B	3C
Decimal	27	60

Range: None

Default: None

Printers: **SRP-270, SRP-275, SRP-280, SRP-500**

Description: This command moves the print head to the standby position.

Remarks:
- The standard position is on the left.
- After processing this command, the print position may be readjusted.

Differences: None

ESC =

Function: **Select peripheral device**

Code:

ASCII	ESC	=	n
Hex	1B	3D	n
Decimal	27	61	n

Range: 1 ≤ n ≤ 3

Default: None

Printers: All printer models except for **SPP-R200**

Description: This command selects the device to which the host computer communicates according to n as follows:

n	Function
1	Enables the printer
2	Disables the printer
3	Enables the printer

Remarks:
- The printer discards all of the received data commands with the exception of ESC = and real-time commands while being disabled.
- The normal operation will be resumed by ESC @, power cycling or printer reset.
- If ASB is activated when the printer is disabled by this command, the status is transmitted to the host at a preset interval.

Differences: None

ESC ?

Function: **Cancel user-defined characters.**

Code:

ASCII	ESC	?	n
Hex	1B	3F	n
Decimal	27	63	n

Range: 32 ≤ n ≤ 126

Default: None

Printers: All printer models except for **SPP-R200**

Description: This command removes user-defined character specified by character code n.

Remarks:
- In place of the deleted user-defined character, the cooresponding resident character is printed.
- The user-defined characters for each font can be deleted independently.

Differences: None

ESC @

Function: **Initialize printer**

Code:

ASCII	ESC	@
Hex	1B	40
Decimal	27	64

Range: None

Default: None

Printers: **All printer models**

Description: This command cancels conditions previously set and initializes the printer to the conditions having existed at power on.

Remarks:

- The data in the printer buffer is cleared.
- The settings of DIP switch are not re-read.
- The data in the receive buffer is not discarded.
- All of the settings such as print mode and line feed are cleared.
- NV graphics and NV user memory are not cleared.
- In page mode, this command removes the data in print areas, restores the initial settings and returns to standard mode.

Differences: None

ESC D

Function: **Set horizontal tab position**

Code:

ASCII	ESC	D	n1...nk	NUL
Hex	1B	44	n1...nk	00
Decimal	27	68	n1...nk	0

Range: 1 ≤ n ≤ 255 , 0 ≤ k ≤ 32

Default: n=8, 16, 24, 32, 40,....., 232, 240, 248

Printers: **All printer models**

Description:
- This command sets the horizontal tab position.
  - n defines the number of columns from the beginning of the line to the horizontal tab setting.
  - k denotes the number of horizontal tab positions to be set.
  - The horizontal tab position is stored as a value of [character width x n] measured form the beginning of the line.

Remarks:
- The data [n]k signifying the set position is transmitted in the ascending order and ends with a NUL code.
- ESC D NUL cancels all horizontal tab positions.
- Tab position is set at the value of [character width x n] from the beginning of the line.
- The character width includes the space to the right of the character, and it will be twice the normal character when the double width characters are selected.
- If the data [n]k is equal to or smaller than the preceding data [n]k-1, the horizontal tab setting has been completed.
- Up to 32 horizontal tabs can be set, the data exceeding this limit is processed as normal ones.
- Even if the character width is changed after setting the horizontal tab positions, the horizontal tab positions remain unchanged.

Differences: None

ESC E

Function: **Turn emphasized mode on / off**

Code:

ASCII	ESC	E	n
Hex	1B	45	n
Decimal	27	69	n

Range: 0 ≤ n ≤ 255

Default: n=0

Printers: **All printer models**

Description:
■ This command turns emphasized mode on or off by toggling the least significant bit of n like following.
- When the LSB of n is 0, emphasized mode is turned off.
- When the LSB of n is 1, emphasized mode is turned on.

Remarks:
■ The setting of this command remains effective until ESC !, ESC @, printer reset or power cycling is executed.

Differences:
■ **SRP-270, SRP-275, SRP-280:**
In the emphasized mode, the print speed will be slow because 2-pass print starts.

ESC G

Function: **Turn double-strike mode on/off**

Code:

ASCII	ESC	G	n
Hex	1B	47	n
Decimal	27	71	n

Range: 0 ≤ n ≤ 255

Default: n=0

Printers: **All printer models**

Description:
■ This command turns double-strike mode on or off by toggling the least significant bit of n like following.
- When the LSB of n is 0, emphasized mode is turned off.
- When the LSB of n is 1, emphasized mode is turned on.

Remarks:
■ The setting of this command remains effective until ESC !, ESC @, printer reset or power cycling is executed.

Differences:
■ **SRP-270, SRP-275, SRP-280:**
In the double-strike mode, the print speed will be slow because 2-pass print starts.

ESC J

Function: **Print and feed paper**

Code:

ASCII	ESC	J	n
Hex	1B	4A	n
Decimal	27	74	n

Range: 0 ≤ n ≤ 255

Default: None

Printers: **All printer models**

Description: This command prints the data in the print buffer and feeds the paper [n X vertical motion unit].

Remarks:

- The maximum feed amount available varies depending on the printer model.
- With standard mode selected, the vertical motion unit is used.
- In page mode, the horizontal motion unit is applied when printing start poison is defined to the upper right or lower right of print area using ESC T, otherwise, the vertical motion unit is used.
- When used in page mode, this command moves only the print position, not executing actual printing.

Differences: Vertical motion unit and maximum feed amount:

Model	Vertical unit	Max feed amount
STP-103 **SRP-352plus** **SRP-352plusN**	0.0625mm (1/406 inches)	15.937mm
SPP-R200	0.125mm (1/203 inches)	31.875mm
SRP-270 **SRP-275** **SRP-280**	0.176mm (1/144 inches)	44.98mm
STP-131 **SRP-350** **SRP-350N** **SRP-350plus** **SRP-350plusN** **SRP-350plusV** **SRP-350plusM**	0.0705mm (1/360 inch)	17.98mm
SRP-500	0.132 mm (1/192 inches)	33.66mm

ESC K

Function: **Print and reverse feed**

Code:

ASCII	ESC	K	n
Hex	1B	4B	n
Decimal	27	75	n

Range: 0 ≤ n ≤ 48

Default: None

Printers: **SRP-270, SRP-275, SRP-280**

Description: This command prints the data in the print buffer and feeds the paper n x (vertical motion unit) in the reverse direction.

Remarks:
- With standard mode selected, the vertical motion unit is used.
- In page mode, the horizontal motion unit is applied when printing start poison is defined to the upper right or lower right of print area using ESC T, otherwise, the vertical motion unit is used.
- When used in page mode, this command moves only the print position, not executing actual printing.
- The reverse paper feeding may cause unexpected problems such as incorrect paper feeding, unusual noise and paper rubbing against the ink ribbon.

Differences: None

ESC L

Function: **Select page mode**

Code:

ASCII	ESC	L
Hex	1B	4C
Decimal	27	76

Range: None

Default: None

Printers: **SPP-R200, SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM**

Description: This command switches from standard mode to page mode.

Remarks:

- For printing in page mode, ESC T defines the print direction and starting position that is within the print area specified by ESC W.
- The conditions by the following commands are defined independently in standard mode and page mode.
  - ESC SP, ESC 2, ESC 3, ESC U, and FS S
- The following commands are not activated in page mode.
  - ESC L, FS q, GS (A, BS ^ E, GS T
- The following commands are not effective in page mode. The conditions set by these commands in page mode are available when the printer returns to standard mode.
  - ESC V, ESC a, ESC {, GS L, and GS W
- The printer resumes standard mode by the use of ESC S, FF, and ESC@
- In page mode, the command, FF, prompts printing the data in the printer buffer collectively. LF, CR, ESC J, and ESC d just move the print position, not performing actual printing.

Differences:

■ **SRP-350, SRP-350N .SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**

(ESC U, FS S) are not supported.

ESC M

Function: **Select character font/ MSR card read**

Code:

ASCII	ESC	M	n
Hex	1B	4D	n
Decimal	27	77	n

Range:

■ **SPP-R200:**
n = 0, 1, 48, 49 , 67, 68, 69, 70, 71, 72, 73

■ **Other printer models:**
n = 0, 1, 48, 49

Default:

■ **SRP-275:**
n=1

■ **Other printer models:**
n=0

Printers: All printer models except for **STP-103, STP-131, SRP-270, SRP-280**

Description: This command selects only-byte character fonts, and magnetic card reader mode that is only available for SPP-R200 using n as following.

n	Function
0, 48	Character font A selected
1, 49	Character font B selected
70	Set 1 track card reader mode
71	Set 2 track card reader mode
72	Set 1,2 track card reader mode
73	Transmits the MSR setting value(s)
67	Set 2 track card reader mode
68	Set 3 track card reader mode
69	Set 2,3 track card reader mode

n	Function
66	Set 1,2,3 track card reader mode
99	Cancel MSR reader mode

■ Magnetic card reader is provided with track 1, 2, and 3.

■ The printer supports 7 options to read the magnetic card by selecting the desired MSR read mode on the utility(VMSM).

■ The following details the magnetic card read output format according to the card reader mode, which is sent to the printer when the magnetic card is read.

Track 1

02H 41H 31H 31H 1CH	DATA max 76 characters	03H 0DH 0AH

Track 2

02H 42H 31H 31H 1CH	DATA 37 characters	03H 0DH 0AH

Track 1,2

02H 43H 31H 31H 1CH 1CH	DATA 76 characters	1CH	DATA 37 Characters	03H 0DH 0AH

Track 3

02H 44H 31H 31H 1CH	DATA104characters	03H 0DH 0AH

Track 2,3

02H 45H 31H 31H 1CH 1CH	DATA 37 characters	1CH	DATA104Characters	03H 0DH 0AH

Track 1,2,3

02H 46H 31H 31H 1CH 1CH	DATA76 characters	1CH	DATA37characters	1CH	DATA104 characters	03H 0DH 0AH

■ The following shows the format of the MSR setting value transmitted to the printer.

	Hexadecimal	Decimal	Amount of Data
Header	37H	55	1 byte
Flag	80H	128	1 byte
Data	41H ~ 48H	65 ~ 72	1 bytes
NUL	00H	0	1 byte

■ The following describes MSR read mode according to the MSR setting value.

MSR setting value(Hex)	MSR read mode
41	Track 1/2/3 read mode command (3 Track case)
42	Track 1 read mode AUTO trigger (3 Track case)
43	Track 2 read mode AUTO trigger (3 Track case)
44	Track 3 read mode AUTO trigger (3 Track case)
45	Track 1/2 read mode AUTO trigger (3 Track case)
46	Track 2/3 read mode AUTO trigger (3 Track case)
47	Track 1/2/3 read mode AUTO trigger (3 Track case)
48	MSR not used

■ The manual reading of a magnetic card is activated with MSR setting value of 41H that is set by **SPP-R200** Unified Utility. In this case, ESC M should be sent to the printer to receive the magnetic card read output prior to swiping the card. In other cases, the printer receives automatically the output whenever the card is read.

Remarks:

■ The printer model has it own configuration of Font A and B.
■ The setting of this command remains effective until ESC !, ESC @, printer reset or power cycling is executed.

Differences:

■ Configuration of Font A and B:
- **STP-103, STP-131, SPP-R200, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
  Font A(12 × 24), Font B(9 x 24)
- **SRP-350, SRP-350N:**
  Font A(12 × 24), Font B(9 x 17)
- **SRP-500:**
  Font A(14 × 12), Font B(12 x 12)

■ MSR read mode selection for **SPP-R200** is specified using **SPP-R200** Unified Utility.

ESC R

Function: **Specify international character set.**

Code:

ASCII	ESC	R	n
Hex	1B	52	n
Decimal	27	82	n

Range:

- **SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
  0 ≤ n ≤ 13
- **STP-103, STP-131:**
  0 ≤ n ≤ 12
- **SPP-R200, SRP-270, SRP-280:**
  0≤ n≤10
- **SRP-275:**
  0≤ n≤11
- **SRP-500:**
  0≤ n≤7, 9

Default: n=0

Printers: **All printer models**

Description: This command specifies international characters according to n values.

n	Character set	n	Character set
0	U.S.A	7	Spain I
1	France	9	Norway
2	Germany	10	Denmark II
3	U.K	11	Spain II
4	Denmark I	12	Latin America
5	Sweden	13	Korea
6	Italy		

Remarks:

■ The setting of this command remains effective until ESC !, ESC @, printer reset or power cycling is executed.

Differences:

■ **SRP-275:**
When n = 11, PC-999 is available. There is no character set specified by n=12, 13.

■ **STP-103, STP-131:**
When n=11, 12, Korea character set is selected.

ESC R S

Function: **Stores international character set to NV memory**

Code:

ASCII	ESC	R	S	n
Hex	1B	52	53	n
Decimal	27	82	83	n

Range: 0 ≤ n ≤ 13

Default: n=0

Printers: **SRP-275**

Description: This command stores international characters specified by n values into the NV memory.

n	Character set	n	Character set
0	U.S.A	7	Spain I
1	France	9	Norway
2	Germany	10	Denmark II
3	U.K	11	Spain II
4	Denmark I	12	Latin America
5	Sweden	13	Korea
6	Italy		

Remarks:

■ The setting of this command remains effective even after ESC @, printer reset or power cycling is executed.

Differences:

■ **SRP-275:**

When n = 11, PC-999 is available. There is no character set specified by n=12, 13.

ESC S

Function: **Select standard mode**

Code:

ASCII	ESC	S
Hex	1B	53
Decimal	27	83

Range: None

Default: None

Printers: **SPP-R200, SRP-350, SRP-350N, SRP-350plus, SRP-352plus, SRP-350plusV, SRP-350plusM**

Description: This command enables standard mode.

Remarks:
- The data in the printer buffer is cleared and the setting by ESC W returns to the default.
- The conditions by the following commands are defined independently in standard mode and page mode.
  - ESC SP, ESC 2, ESC 3, ESC U, and FS S
- In standard mode, CAN, ESC FF, GS $, and GS \ are ignored.

Differences:
- **SRP-350, SRP-350N, 350plus, SRP-350plusN, 352plus, 352plusN, SRP-350plusV, SRP-350plusM:** (ESC U,ESC FF,FS S) is not supported.

ESC T

Function: **Select print direction in page mode**

Code:

ASCII	ESC	T	n
Hex	1B	54	n
Decimal	27	84	n

Range: 0 ≤ n ≤ 3, 48 ≤ n ≤ 51

Default: n = 0

Printers: **SPP-R200, SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM**

Description: This command selects the print direction and starting position in page mode.

n	Print Direction	Starting Position
0,48	Left right	Upper left
1,49	Bottom to top	Lower left
2,50	Right left	Lower right
3,51	Top bottom	Upper right

Remarks:

- The print direction set by this command id not effective in standard mode.
- If this command is processed in standard mode, the setting by this command is effective when the printer changes to page mode.
- Depending on the print starting position set by this command, the horizontal motion unit or vertical motion unit is used for the following commands.
  - When the starting position is the upper left or lower right of the print area; ESC SP, ESC $, ESC \ use the horizontal motion unit and ESC 3, ESC J, GS $, GS \ the vertical motion unit.
  - When the starting position is the upper right or lower left of the print area; ; ESC SP, ESC $, ESC \ use the vertical motion unit and ESC 3, ESC J, GS $, GS \ the horizontal motion unit.
- The setting of this command remains effective until ESC !, ESC @, printer reset or power cycling is executed.

Differences: None

ESC U

Function: **Specify unidirectional print mode**

Code:

ASCII	ESC	U	n
Hex	1B	55	n
Decimal	27	85	n

Range: 0 ≤ n ≤ 255

Default: n = 0

Printers: **SRP-270, SRP-275, SRP-280, SRP-500**

Description:
- This command selects/deselects the unidirectional print according to the value of n that is valid only for the least significant bit.
  - Unidirectional print mode is turned on with n=0, and turned off with n=1

Remarks:
- In this mode, the printer will print from the left to the right, preventing horizontal shear in printing, in particular, for double height print.
- The setting of this command remains effective until ESC !, ESC @, printer reset or power cycling is executed.

Differences: None

ESC V

Function: **Turn 90°clockwise rotation mode on/off**

Code:

ASCII	ESC	V	n
Hex	1B	56	n
Decimal	27	86	n

Range: 0 ≤ n ≤ 2, 48 ≤ n ≤ 50

■ **STP-103, STP-131, SRP-350, SRP-350N:**
0 ≤ n ≤ 1, 48 ≤ n ≤ 49

Default: n = 0

Printers: **SPP-R200, SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM**

Description:
■ This command turns 90° clockwise rotation mode on/off in standard mode according to the value of n as following
- When the value of n is equal to 0 or 48, 90°clockwise rotation mode is turned off.
- When the value of n is equal to 1, 2, 48, or 50, 90°clockwise rotation mode is turned on.

Remarks:
■ In underline mode, the underline printing for 90° clockwise rotated characters does not work, and the relationship between vertical and horizontal directions is reversed.
■ The 90° clockwise rotation mode is not effective in page mode.
■ If set in page mode, the 90° clockwise rotation mode has effect after the printer returns to standard mode.
■ The setting of this command remains effective until ESC !, ESC @, printer reset or power cycling is executed.

Differences: None

ESC W

Function: **Set print area in page mode**

Code:

ASCII	ESC	W	xL	xH	yL	yH	dxL	dxH	dyL	dyH
Hex	1B	57	xL	xH	yL	yH	dxL	dxH	dyL	dyH
Decimal	27	87	xL	xH	yL	yH	dxL	dxH	dyL	dyH

Range:

0 ≤ (xL + xH x 256) ≤ 65535 (0 ≤ xL ≤ 255, 0 ≤ xH ≤ 255)
0 ≤ (yL + yH x 256) ≤ 65535 (0 ≤ yL ≤ 255, 0 ≤ yH ≤ 255)
1 ≤ (dxL + dxH x 256) ≤ 65535 (0 ≤ dxL ≤ 255, 0 ≤ dxH ≤ 255)
1 ≤ (dyL + dyH x 256) ≤ 65535 (0 ≤ dyL ≤ 255, 0 ≤ dyH ≤ 255)

Default:

■ **SPP-R200:**
- When paper width of 58mm is selected:
  (xL + xH x 256) = 0 (xL=0, xH=0)
  (yL + yH x 256) = 0 (yL=0, yH=0)
  (dxL + dxH x 256) = 384 (dxL=128, dxH=1)
  (dyL + dyH x 256) = 840 (dyL=72, dyH=3)

■ **SRP-350, SRP-350plus, SRP-350plusV, SRP-350plusM:**
- When a paper width of 80mm{3.15"} is selected:
  (xL + xH x 256) = 0 (xL=0, xH=0)
  (yL + yH x 256) = 0 (yL=0, yH=0)
  (dxL + dxH x 256) = 512 (dxL=0, dxH=2)
  (dyL + dyH x 256) = 1662 (dyL=126, dyH=6)

■ **SRP-350N:**
- When a paper width of 50mm{2"} is selected:
  (xL + xH x 256) = 0 (xL=0, xH=0)
  (yL + yH x 256) = 0 (yL=0, yH=0)
  (dxL + dxH x 256) = 354 (dxL=98, dxH=1)
  (dyL + dyH x 256) = 1662 (dyL=126, dyH=6)

■ **SRP-350plusN:**
- When a paper width of 60mm{2.36"} is selected:
  (xL + xH x 256) = 0 (xL=0, xH=0)
  (yL + yH x 256) = 0 (yL=0, yH=0)
  (dxL + dxH x 256) = 360 (dxL=104, dxH=1)
  (dyL + dyH x 256) = 1662 (dyL=126, dyH=6)

■ **SRP-352plus:**
- When a paper width of 80mm{3.15"} is selected:
  (xL + xH x 256) = 0 (xL=0, xH=0)
  (yL + yH x 256) = 0 (yL=0, yH=0)
  (dxL + dxH x 256) = 576 (dxL=64, dxH=2)
  (dyL + dyH x 256) = 1662 (dyL=126, dyH=6)

■ **SRP-352plusN:**
- When a paper width of 60mm{2.36"} is selected:
  (xL + xH x 256) = 0 (xL=0, xH=0)
  (yL + yH x 256) = 0 (yL=0, yH=0)
  (dxL + dxH x 256) = 384 (dxL=128, dxH=1)
  (dyL + dyH x 256) = 1662 (dyL=126, dyH=6)

Printers: All printer models except for **STP-103, STP-131, SRP-270, SRP-280, SRP-275, SRP-500**

Description:
■ This command set the position and the size of the printing area in page mode as following.
- Horizontal starting position = [(xL + xH x 256) x (horizontal motion units)]
- Vertical starting position = [(yL + yH x 256) x (vertical motion units)]
- Horizontal printing area width = [(dxL + dxH x 256) x (horizontal motion units)]
- Vertical printing area width = [(dyL + dyH x 256) x (vertical motion units)]

Remarks:
■ The horizontal and vertical starting positions are out of the printable area, this command is canceled and the following data is processed as normal data.
■ If (Horizontal starting position + Horizontal printing area width) is beyond the printable area, the Horizontal printing area width is set to (Horizontal printing area - Horizontal starting position).
■ If (Vertical starting position + Vertical printing area width) is beyond the printable area, the Vertical printing area width is set to (Vertical printing area - Vertical starting position).

■ This command is not effective in standard mode. If this command is processed in standard mode, the setting by this command is effective when the printer returns to page mode.
■ The setting of this command remains effective until ESC !, ESC @, printer reset or power cycling is executed.

Differences: The maximum printable area(Max horizontal printable area, Max vertical printable area):

Model	Max horizontal printable area	Max vertical printable area
SPP-R200	48mm(384dots)	105mm(840dots)
SRP-350 **SRP-350plus** **SRP-350plusV** **SRP-350plusM**	72.2mm(512dots)	234.3mm(1662dots)
SRP-350N	49.9mm(354dots)	234.3mm(1662dots)
SRP-350plusN	50.76mm(360dots)	234.3mm(1662dots)
SRP-352plus	72mm(576dots)	207.75mm(1662dots)
SRP-352plusN	48mm(384dots)	207.75mm(1662dots)

ESC \

Function: **Set relative print position**

Code:

ASCII	ESC	\	nL	nH
Hex	1B	5C	nL	nH
Decimal	27	92	nL	nH

Range: 0 ≤ (nL + nH x 256) ≤ 65535 (0 ≤ nL 255, 0 ≤ nH ≤ 255)

Default: None

Printers: **SPP-R200, SRP-350, SRP-350N, SRP-350plus, SRP-352plus, SRP-350plusV, SRP-350plusM**

Description:
- This command sets the print starting position based on the current position to [(nL + nH × 256) × horizontal or vertical motion unit]
  - The print starting position is moved to (nL + nH x 256)in the right direction based on the current position

Remarks:
- The printer ignores any setting that exceeds the print area.
- When the print area has been exceeded, this command is ignored.
- With standard mode selected, the vertical motion unit is used.
- In page mode, the horizontal motion unit is applied when printing start poison is defined to the upper right or lower right of print area using ESC T, otherwise, the vertical motion unit is used.
- Even if the underline mode is turned on, the space skipped by this command is not printed underlined.

Differences: None

ESC a

Function: **Set position alignment**

Code:

ASCII	ESC	a	n
Hex	1B	61	n
Decimal	27	97	n

Range: 0 ≤ n ≤2, 48 ≤ n ≤50

Default: n=0

Printers: **All printer models**

Description: This command specifies position alignment for all data in one line in standard mode, using n as follows:

n	Alignment
0, 48	Left alignment
1, 49	Center alignment
2, 50	Right alignment

Remarks:
- This command is not effective in page mode. If this command is processed in page mode, the setting by this command becomes effective when the printer returns to standard mode.
- The setting of this command remains effective until ESC !, ESC @, printer reset or power cycling is executed.

Differences: None

ESC d

Function: **Print and feed n lines.**

Code:

ASCII	ESC	d	n
Hex	1B	64	n
Decimal	27	100	n

Range: 0 ≤ n ≤ 255

Default: None

Printers: **All printer models**

Description: This command feeds the paper by n lines after printing the data in the print buffer.

Remarks:
- The per-line paper feed amount is based on the value set by the line spacing related commands, ESC 2 and ESC 3.
- In page mode, this command moves only the print position, not performing actual print.
- If the feed amount set is beyond the maximum feed amount, the feed amount will be set to the maximum feed amount automatically.

Differences:
- **SPP-R200, SRP-275, SRP-500:**
  Maximum feed amount: 255 lines.

ESC e

Function: **Print and reverse feed n lines.**

Code:

ASCII	ESC	e	n
Hex	1B	65	n
Decimal	27	101	n

Range: 0 ≤ n ≤ 1

Default: None

Printers: **SRP-270, SRP-275, SRP-280**

Description:
- This command feeds the paper by n lines in the reverse direction after printing the data in the print buffer.

Remarks:
- The per-line paper feed amount is based on the value set by the line spacing related commands, ESC 2 and ESC 3.
- In page mode, this command moves only the print position, not performing actual print.

Differences:
- **SRP-275**
  The maximum reverse paper feed amount is 1 line to prevent the paper jam and paper rubbing against the ink ribbon.

ESC g 0

Function: **Define macro**

Code:

ASCII	ESC	g	0	<k> [<n_H > <n_L>]$_k$ [d1…dm]$_k$
Hex	1B	67	00	<k> [<n_H > <n_L>]$_k$ [d1…dm]$_k$
Decimal	27	103	0	<k> [<n_H > <n_L>]$_k$ [d1…dm]$_k$

Range:
$k \le 10$
$0 \le n_L \le 255$
$0 \le n_H \le 255$
$[(256\times n_H) + n_L]_1 + \ldots.. + [(256\times n_H) + n_L]_k$ < 2Mbit (256KB)
$0 \le d \le 255$

Default: None

Printers: **SRP-275, SRP-500**

Description:
- This command defines macro into NV memory such as a logo image.
  - k denotes the total number of macro to be stored in NV memory.
  - m=(256× n_H) + n_L specifies the size of macro in byte

Remarks:
- 2M bit (256KB) of the flash is allocated for saving NV bit image.
- This command is useful to define NV bit image (Logo).
- The NV bit image is printed by ESC g n.

Differences: None

ESC g n

Function: **Execute macro**

Code:

ASCII	ESC	g	n
Hex	1B	67	n
Decimal	27	103	n

Range: 1 ≤ n ≤ 10

Default: None

Printers: **SRP-275, SRP-500**

Description:
- This command executes macro using the value of n.
  - n denotes the macro index number that is automatically given to the macro in a downloading order while being defined by ESC g.

Remarks:
- The NV bit image should be defined by ESC g preceding this command. When executing the macro not being defined, this command is ignored.

Differences: None

ESC i

Function: **Partial cut**

Code:

ASCII	ESC	i
Hex	1B	69
Decimal	27	105

Range: None

Default: None

Printers: All printer models except for **STP-103, SPP-R200**

Description: This command executes a partial cut of the paper with one point left uncut.

Remarks:
- The same partial cut as this command is executed using ESC m and GS V.

Differences:
- This command is effective for the printer equipped with an autocutter.
- Autocutter operation should be enabled by setting the autocutter control DIP switch.
- If the autocutter control DIP switch of the printer not equipped with autocutter is set, the printer does not operate, displaying the error signal by LED.

ESC m

Function: **Partial cut**

Code:

ASCII	ESC	m
Hex	1B	6D
Decimal	27	109

Range: None

Default: None

Printers: All printer models except for **STP-103, STP-131, SPP-R200**

Description: This command executes a partial cut of the paper with one point left uncut.

Remarks:
- The same partial cut as this command is executed using ESC i and GS V.

Differences:
- This command is effective for the printer equipped with an autocutter.
- Autocutter operation should be enabled by setting the autocutter control DIP switch.
- If the autocutter control DIP switch of the printer not equipped with autocutter is set, the printer does not operate, displaying the error signal by LED.

ESC p

Function: **Generate pulse**

Code:

ASCII	ESC	p	m	t1	t2
Hex	1B	70	m	t1	t2
Decimal	27	112	m	t1	t2

Range: m = 0, 1, 48, 49
0 ≤ t1 ≤ 255, 0 ≤ t2 ≤ 255

Default: None

Printers: All printer models except for **SPP-R200**

Description: This command outputs the signals specified with t1 and t2 to the connector pins defined by m.

m	**Connector pin**
0, 48	Drawer kick-out connector pin 2
1, 49	Drawer kick-out connector pin 5

Remarks:

■ The ON time is [t1 x 2ms], and the OFF time is as [t2 x 2ms].
- If t2 is smaller than t1, OFF time is set to [t1 x 2ms].

Differences: None

ESC r

Function: **Select print color**

Code:

ASCII	ESC	r	n
Hex	1B	72	n
Decimal	27	114	n

Range: n = 0, 1, 48, 49

Default: n = 0

Printers: **SRP-270, SRP-275, SRP-500**

Description:
- This command selects a print color for each line, using n as follows.
  - When n = 0 or 48, black is selected.
  - When n=1 or 49, red is selected.

Remarks:
- In standard mode, this command is valid only when processed at the beginning of the line.
- In page mode, the color selected by this command is applied to all data collectively printed by FF.
- GS (N and GS (L can be used to specify two-color printing.
- The setting of this command remains effective until ESC !, ESC @, printer reset or power cycling is executed.

Differences: None

ESC t

Function: **Select character code table**

Code:

ASCII	ESC	t	n
Hex	1B	74	n
Decimal	27	116	n

Range: 0 ≤ n ≤ 5, 16 ≤ n ≤ 19, 21 ≤ n ≤ 31, 33 ≤ n ≤ 41, n=255

Default: For model not supporting Thai character: n=0
For model supporting Thai character support : n = 20

Printers: **All printer models**

Description: This command specifies code page according to the value of n as follows:

n	Code page	
0	Page 0	437 (USA, Standard Europe)
1	Page 1	Katakana
2	Page 2	850 (Multilingual)
3	Page 3	860 (Portuguese)
4	Page 4	863 (Canadian-French)
5	Page 5	865 (Nordic)
16	Page 16	1252 (Latin I)
17	Page 17	866 (Cyrillic #2)
18	Page 18	852 (Latin 2)
19	Page 19	858 (Euro)
21	Page 21	862 (Hebrew DOS code)
22	Page 22	864 (Arabic)
23	Page 23	Thai42
24	Page 24	1253 (Greek)
25	Page 25	1254 (Turkish)

n	Code page
26	Page 26 1257 (Baltic)
27	Page 27 Farsi
28	Page 28 1251 (Cyrillic)
29	Page 29 737 (Greek)
30	Page 30 775 (Baltic)
31	Page 31 Thai14
33	Page 33 1255 (Hebrew New code)
34	Page 34 Thai 11
35	Page 35 Thai 18
36	Page 36 855 (Cyrillic)
37	Page 37 857 (Turkish)
38	Page 38 928 (Greek)
39	Page 39 Thai 16
40	Page 40 1256 (Arabic)
41	Page 41 1258 (Vietnam)
255	User Code Page (Space)

Remarks: ■ The setting of this command remains effective until ESC !, ESC @, printer reset or power cycling is executed.

Differences: Code pages not supported:

■ **STP-103, STP-131:**
6 ≤ n ≤ 18, 20 ≤ n ≤ 41

■ **SPP-R200:**
n = 41. When n=255, the code page specified by the memory switch is enabled.

■ **SRP-270:**
16 ≤ n ≤ 18, 21≤ n ≤ 40

■ **SRP-275:**
n = 36, 39, 40
When n=255, the code page specified by the memory switch is enabled.

■ **SRP-280:**
16 ≤ n ≤ 18, 21≤ n ≤ 40

■ **SRP-350, SRP-350N:**
6 ≤ n ≤ 18, 20 ≤ n ≤ 41

■ **SRP-500:**
n = 1, 25, 28, 30, 32,33, 36,37, 39,40,41
When n=255, code page 0(437) is selected.

ESC u

Function: **Transmit peripheral device status**

Code:

ASCII	ESC	u	n
Hex	1B	75	n
Decimal	27	117	n

Range: n = 0, 48

Default: None

Printers: **SRP-270, SRP-275, SRP-280**

Description: This command transmits a byte of data with the least significant bit(LSB) specifying the peripheral device status as follows:

LSB	Status of drawer kick-out connector pin 3
0	Low
1	High

Remarks: ■ The peripheral device status can be transmitted using GS r.

Differences: None

ESC v

Function: **Transmit paper sensor status**

Code:

ASCII	ESC	v
Hex	1B	76
Decimal	27	118

Range: None

Default: None

Printers: **SRP-270, SRP-275, SRP-280, SRP-500, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM**

Description:

- This command transmits a byte of data specifying the paper sensor status.
- The status of paper near end and paper end sensors is sent to the host as follows:
  - When paper near end is detected, 0x03 is transmitted.
  - When paper end is detected, 0xC is transmitted.

Remarks:

- The paper sensor status can be transmitted using GS r.
- The near end senor is optional while paper end sensor required.
- If the printer is not equipped with a near end sensor, the paper near end sensor is considered as normal condition.

Differences: None

ESC {

Function: **Turns upside-down printing mode on/off**

Code:

ASCII	ESC	{	n
Hex	1B	7B	n
Decimal	27	123	n

Range: 0 ≤ n ≤ 255

Default: n=0

Printers: **All printer models**

Description: This command selects/deselects upside-down printing mode according to the least significant bit as follows.

LSB	Upside-down mode
0	Turned off
1	Turned on

Remarks:

- This command is valid only when entered at the beginning of the line.
- The upside-down print mode has no effect in page mode. If this command is processed in page mode, upside-down printing mode is enabled when the printer returns to standard mode.
- 180 rotated characters are printed from right to left in upside-down print mode.
- The setting of this command remains effective until ESC !, ESC @, printer reset or power cycling is executed.

Example

Normal	Upside- down Mode
ABCDEF	ABCDEF

Differences: None

FS !

Function: **Set print mode for Kanji characters**

Code:

ASCII	FS	!	n
Hex	1C	21	n
Decimal	28	33	n

Range: 0 ≤ n ≤ 255

Default: n=0

Printers: **SRP-275, SRP-280**

Description: This command signifies the print modes such as double-width mode, double-height mode, and underline mode for Kanji characters as follows:

Bit	Binary	Hex	Decimal	Status
0	Off	00	0	Reserved
1	Off	00	0	Reserved
2	Off	00	0	Double-width mode is Off
	On	04	4	Double-width mode is On
3	Off	00	0	Double-height mode is Off
	On	08	8	Double-height mode is On
4-6	Off	00	0	Reserved
7	Off	00	0	Kanji underline mode is Off
	On	80	128	Kanji underline mode is Off

Remarks:

- Kanji underline mode can be set using FS -.
- Double-width and height modes can be set using GS !.
- In Kanji underline mode, the underline printing is not performed under 90°clockwise rotated characters, white/black reverse characters, and spaces skipped by HT, ESC $, or ESC \.
- The setting of this command remains effective until ESC !, ESC @, printer reset or power cycling is executed.

Differences: None

FS &

Function: **Select Kanji character mode**

Code:

ASCII	FS	&
Hex	1C	26
Decimal	28	38

Range: None

Default: None

Printers: **SRP-275, SPP-R200**

Description: This command sets Kanji character mode.

Remarks:
- This command is available only for the Japanese, Chinese, and Korean models.
- Kanji codes are comprised of 2 bytes and processed in order of the first and second byte.
- The setting of this command remains effective until ESC !, ESC @, printer reset, power cycling or FS is executed.

Differences: None

FS -

Function: **Turn underline mode on/off for Kanji characters**

Code:

ASCII	FS	-	n
Hex	1C	2D	n
Decimal	28	45	n

Range: 0 ≤ n ≤ 1, 48 ≤ d ≤ 49

Default: n=0

Printers: **SRP-275, SRP-280**

Description:

n	Underline mode for Kanji characters
0, 48	Turned off
1, 49	Turned on

This command select/deselects underline mode for Kanji characters, based on the following values of n:

Remarks:
- Kanji underline mode can be set using FS !.
- The settings of this command are valid only for Kanji characters.
- The setting of this command remains effective until ESC !, ESC @, printer reset, or power cycling is executed.

Differences: None

FS .

Function: **Cancel Kanji character mode**

Code:

ASCII	FS	.
Hex	1C	2E
Decimal	28	46

Range: None

Default: None

Printers: **SPP-R200, SRP-275**

Description: This command cancels Kanji character mode.

Remarks:

- This command is available only for the Japanese, Chinese, and Korean models.
- Kanji character mode is enabled using FS &.
- Once Kanji character mode is canceled, the printer processes a character code as 1-byte code of alphanumeric characters.
- The setting of this command remains effective until ESC !, ESC @, printer reset, or power cycling is executed.

Differences: None

FS 2

Function: **Specify user-defined Kanji characters**

Code:

ASCII	FS	2	c1	c2	d1...dk
Hex	1C	32	c1	c2	d1...dk
Decimal	28	50	c1	c2	d1...dk

Range: c1 = FEH, A1H ≤ c2 ≤ FEH
0 ≤ d ≤ 255
k = 32

Default: None

Printers: **SRP-275**

Description:
- This command defines user-defined Kanji characters for the character codes specified by c1 and c2.
  - c1 and c2 denote the first and second byte of a character code respectively for a user-defined character.
  - d indicates 1 byte of defined data.
  - k indicates the maximum number of defined data.

Remarks:
- The bits of defined data (d) include 1 to print a dot or 0 not to print a dot.
- Defined data remains effective until ESC !, ESC @, printer reset, or power cycling is executed.
- In case user-defined characters are not defined, space is printed at the default.
- The relationship between the defined data and a print result is as follows. (2 bytes in vertical × 16 dots in horizontal) is necessary.

d1	d3	d5	...	d27	d29	d31	MSB LSB
d2	d4	d6	...	d28	d30	d32	MSB LSB

Differences: None

FS p

Function: **Print NV bit image**

Code:

ASCII	FS	p	n	m
Hex	1C	70	n	m
Decimal	28	112	n	m

Range: 1 ≤ n ≤ 255
0 ≤ m ≤ 3, 48 ≤ m ≤ 51

Default: None

Printers: All the printer models except for **SPP-R200, SRP-270, SRP-280, SRP-500**

Description: This command prints NV bit image n using the mode specified by m as follows:

m	Mode
0, 48	Normal
1, 49	Double-width
2, 50	Double-height
3, 51	Quadruple

Remarks:
- BS ^ L and BS ^ 7 can be used for printing NV bit image.
- The NV bit image is defined by FS q.
- n is assigned to each NV bit image to be stored in download order by FS q.
- This command has no effect with NV bit image not defined in advance.
- In page mode, the NV bit image is saved without being printed.
- The printer does not print the NV bit image that is beyond one line of print area.
- When using unidirectional print mode, there will be no vertical misali gnment between the top and bottom parts of the printed pattern.

Differences:

■ **STP-103, SRP-352plus, SRP-352plusN:**

DPI : Dots per Inch (25.4mm)

Mode	Vertical Dot Density (DPI)	Horizontal Dot Density (DPI)
Normal	203	203
Double-width	203	203/2
Double-height	203/2	203
Quadruple	203/2	203/2

■ **STP-131, SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-350plusV, SRP-350plusM:**

DPI : Dots per Inch (25.4mm)

Mode	Vertical Dot Density (DPI)	Horizontal Dot Density (DPI)
Normal	180	180
Double-width	180	90
Double-height	90	180
Quadruple	90	90

■ **SRP-275:**

DPI : Dots per Inch (25.4mm)

Mode	Vertical Dot Density (DPI)	Horizontal Dot Density (DPI)
Normal	72	160
Double-width	72	80
Double-height	N/A	
Quadruple	N/A	

FS q

Function: **Define NV bit image**

Code:

ASCII	FS	q	n	[xL xH yL d1...dk]1... [xL xH yL d1...dk]n
Hex	1C	71	n	[xL xH yL d1...dk]1... [xL xH yL d1...dk]n
Decimal	28	113	n	[xL xH yL d1...dk]1... [xL xH yL d1...dk]n

Range:
1 ≤ n ≤ 255
1 ≤ (xL + xH ×256) ≤ 1023 (0 ≤ xL ≤ 255, 0 ≤ xH ≤ 3)
1 ≤ (yL + yH ×256) ≤ 288 (0 ≤ yL ≤ 255, yH=0,1)
0 ≤ d ≤ 255
k = (xL + xH × 256) × (yL + yH × 256) × 8

Default: None

Printers: All the printer models except for **SPP-R200, SRP-270, SRP-280, SRP-500**

Description:
- This command defines the NV bit image in the NV memory.
  - n denotes the number of the NV being defined.
  - (xL, xH) and (yL, yH) set the number of dots in the horizontal and vertical directions to [(xL + xH × 256) x 8] and [(yL + yH × 256) x 8] respectively for the NV bit image.

Remarks:
- BS ^ L and BS ^ 7 can be used for defining NV bit image.
- When this command is entered, all NV bit images previously defined are removed from the NV memory.
- After completion of this command, the printer executes a software reset to restore the settings as when turned on.
- The NV bit image is printed by FS p.

■ During the execution of this command, paper feed button, ASB and real time functions will not operate.
are as follo▪ Bit image data and print result ws:

d1	dY+1	…	. . .	MSB LSB
d2	dY+2	…	dk-2	MSB LSB
. . .	. . .	…	dk-1	MSB LSB
dY	dY x 2	…	dk	MSB LSB

Differences:

■ **STP-103, STP-131, SRP-350, SRP-350N, SRP-275:**
The capacity of NV memory available is 256KB.

■ **SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
NV memory is devided into 2 areas for mono and 2-color graphics. The capacity of each NV memory area is 256KB.

FS S

Function: **Set Kanji character spacing**

Code:

ASCII	FS	S	n1	n2
Hex	1C	53	n1	n2
Decimal	28	83	n1	n2

Range: 0 ≤ n1 ≤ 32, 0 ≤ n2 ≤ 32

Default: n1 = 0, n2 = 0

Printers: **SRP-275, SRP-280**

Description:
- This command sets left- and right-side spacing for Kanji characters, n1 and n2 respectively.
  - Left-side character spacing is [n1×horizontal unit].
  - Right-side character spacing is [n2×horizontal unit].

Remarks:
- In a double width mode, the right space will be doubled.
- The character spacing can be set independently for standard and page modes.
- The setting of this command remains effective until ESC !, ESC @, printer reset or power cycling is executed.

Differences: None

FS W

Function: **Turn quadruple-size mode on/off for Kanji characters**

Code:

ASCII	FS	W	n
Hex	1C	57	n
Decimal	28	87	n

Range: 0 ≤ n ≤ 1

Default: n = 0

Printers: **SRP-275**

Description: This command turns quadruple-size mode on or off for Kanji characters, using a least significant bit of n as follows:

n	Quadruple-size mode
0	Turned off
1	Turned on

Remarks:
- FS ! or GS ! can be used to generate the quadruple-size Kanji characters.
- The setting of this command remains effective until ESC @, printer reset or power cycling is executed.

Differences: None

FS ?

Function: **Cancel user-defined Kanji characters**

Code:

ASCII	FS	?	c1	c2
Hex	1C	3F	c1	c2
Decimal	28	63	c1	c2

Range: c1 = FEH, A1H ≤ c2 ≤ FEH

Default: None

Printers: **SRP-275**

Description:
- This command cancels user-defined Kanji characters for the character codes specified by c1 and c2.
  - c1 and c2 specify the first and second byte of a character code for a user-defined Kanji character respectively.

Remarks:
- This command is effective only for Chinese model.
- A space is printed for the user-defined Kanji character canceled.

Differences: None

GS !

Function: **Select character size**

Code:

ASCII	GS	!	n
Hex	1D	21	n
Decimal	29	33	n

Range: 0 ≤ n ≤ 255
(1 ≤ Vertical enlargement ≤ 8, 1 ≤ Horizontal enlargement ≤ 8)

Default: n=0

Printers: All printer models other than **SRP-270, SRP-275, SRP-280, SRP-500**

Description: ■ This command selects the character height and width using bits 0 to 3, and bits 4 to 7 respectively as follows:

Bit	Function	Setting
0	Specifies the number of times normal font size in the vertical direction	Refer to Table 2 [Enlarged in vertical direction]
1		
2		
3		
4	Specifies the number of times normal font size in the horizontal direction	Refer to Table 1 [Enlarged in horizontal direction]
5		
6		
7		

• Table 1 [Enlarged in horizontal direction]

Hex	Decimal	Enlargement
00	0	1 time (standard)
10	16	2 times
20	32	3 times
30	48	4 times
40	64	5 times
50	80	6 times
60	96	7 times
70	112	8 times

• Table 2 [Enlarged in vertical direction]

Hex	Decimal	Enlargement
00	0	1 time (standard)
01	1	2 times
02	2	3 times
03	3	4 times
04	4	5 times
05	5	6 times
06	6	7 times
07	7	8 times

Remarks:

- The character size set by this command is valid for alphanumeric, user-defined characters, multi-byte code characters such as Chinese, Japanese, and Korean.
- Double width and double height modes can be set by ESC !.
- Multi-byte code characters are specified only by this command.
- The setting of this command remains effective until ESC @, printer reset or power cycling is executed.

Differences: None

GS $

Function: **Set absolute vertical print position in page mode**

Code:

ASCII	GS	$	nL	nH
Hex	1D	24	nL	nH
Decimal	29	36	nL	nH

Range: 0 ≤ (nL + nH x 256) ≤ 65535 (0 ≤ nL ≤ 255, 0 ≤ nH ≤ 255)

Default: None

Printers: All printer models except for **STP-103, STP-131, SRP-270, SRP-280, SRP-275, SRP-500**

Description: This command sets the absolute vertical print starting position to [(nL + nH × 256) × (vertical or horizontal motion unit)].

Remarks:
- This command is activated only in page mode and ignored in standard mode.
- Either vertical or horizontal motion unit is used according to the print direction set by ESC T as follows:
  - With the starting position of the upper left or lower right on the print area, the vertical motion unit is used.
  - In other cases, the horizontal motion unit is used.
- The configuration beyond the print area set by ESC W is ignored.

Differences: None

GS (A

Function: **Execute test print**

Code:

ASCII	GS	(	A	pL	pH	n	m
Hex	1D	28	41	pL	pH	n	m
Decimal	29	40	65	pL	pH	n	m

Range: (pL + pH x 256) = 2 (pL=2, pH=0)
0 ≤ n ≤ 2, 48 ≤ n ≤ 50

■ **SPP-R200, SRP-275, SRP-500:**
1 ≤ m ≤ 3, 49 ≤ m ≤ 51

■ **SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
1 ≤ m ≤ 2, 49 ≤ m ≤ 50

Default: None

Printers: All printer models except for **STP-103, STP-131, SRP-270, SRP-280, SRP-350, SRP-350N**

Description: ■ This command prints a specified pattern for testing on a roll paper.

• Roll paper is selected with n specified as follows:

n	Paper type
0, 48 1, 49 2, 50	Roll paper

• Different kinds of test patterns are selected according to m as follows:

m	Test pattern
1, 49	Hexadecimal dump mode
2, 50	Printer configuration printing
3, 51	Rolling pattern printing

Remarks:

- The printer cancels a macro definition in progress If this command is processed. The macro becomes invalid.
- After completion of this command, a software reset is executed automatically to restore the printer status set during power cycling.
- All of the data transmitted from the host to the printer is printed and identified in hexadecimal dump mode.
- The real time command and ASB operations are not executed during the printing of printer configuration (m=2, 50) and rolling pattern (m=3, 51).

Differences:

- **SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**

m	Test pattern
1, 49	Hexadecimal dump mode
2, 50	Self-test printing(configuration+default codepage)
3, 51	Not operated

GS (F

Function: **Set black mark control functions**

Code: None

Range: None

Default: None

Printers: ■ **SRP-350plusV, SRP-350plusM:**
Supporting Function 1,2,112

Description: ■ This command performs various functions to control the black mark(BM) paper as follows:

m	Format	Function
1	GS (F pL pH m a nL nH	Sets the paper feed amount to adjust the print starting position after sensing BM.
2	GS (F pL pH m a nL nH	Sets the paper feed amount to adjust the paper cutting position after sensing BM.
112	GS (F pL pH m aL aH bL bH	Specifies the black mark paper format.

• pL, pH specifies (pL + (pH ×256)) as the number of bytes after pH (m and [parameter]).

Remarks: ■ This command is effective only when the BM(black mark) sensor is enabled.
■ This command is stored in the receive buffer and processed in FIFO so that the delay in execution of this command might be occurred.

Differences: None

<Function 1> GS (F pL pH m a nL nH (m=1)

Code:

ASCII	GS	(	F	pL	pH	m	a	nL	nH
Hex	1D	28	46	04	00	01	a	nL	nH
Decimal	29	40	70	4	0	1	a	nL	nH

Range:

(pL + pH × 256) = 4 (pL = 4, pH = 0)
m = 1
a = 0, 48
0 ≤ (nL + nH × 256) ≤ 65535 (0 ≤ nL ≤ 255, 0 ≤ nH ≤ 255)

Default:

nL = 0, nH = 0

Description:

■ This command sets the value for the adjustment of print starting position after sensing BM.
- pL, pH specifies (pL + pH × 256) as the number of bytes after pH (m, a, nL, and nH)
- nL, nH specifies [(nL + nH × 256) × vertical motion units] as the adjustment value.

Remarks:

■ This command affects to the execution of the command FF.
■ This command is only effective for the forward paper feeding.
■ The maximum adjustable length is 400 mm. If the adjustment value to be specified exceeds the maximum value, the adjustment value is automatically set to the maximum value.

Differences:

None

<Function 2> GS (F pL pH m a nL nH (m=2)

Code:

ASCII	GS	(	F	pL	pH	m	a	nL	nH
Hex	1D	28	46	04	00	02	a	nL	nH
Decimal	29	40	70	4	0	2	a	nL	nH

Range:

(pL + pH × 256) = 4 (pL = 4, pH = 0)
m = 2
a = 0, 48
0 ≤ (nL + nH × 256) ≤ 65535 (0 ≤ nL ≤ 255, 0 ≤ nH ≤ 255)

Default:

nL = 0, nH = 0

Description:

■ This command sets the value for the adjustment of paper cutting position after sensing BM.
- pL, pH specifies (pL + pH × 256) as the number of bytes after pH (m, a, nL, and nH)
- nL, nH specifies [(nL + nH × 256) × vertical motion units] as the adjustment value.

Remarks:

■ This command affects to the cutting operations as follows:
- Paper cut by GS V m n.
- Paper cut after paper feeding triggered by the paper FEED button.
- Paper cut after initializing the BM.(optional)
- Paper cut after paper feeding with the cover closed.(optional)

■ This command is only effective for the forward paper feeding.

■ The maximum adjustable length is 400 mm. If the adjustment value to be specified exceeds the maximum value, the adjustment value is automatically set to the maximum value.

Differences:

None

<Function 112> GS (F pL pH m aL aH bL bH (m=112)

Code:

ASCII	GS	(	F	pL	pH	m	aL	aH	bL	bH
Hex	1D	28	46	05	00	70	aL	aH	bL	bH
Decimal	29	40	70	5	0	112	aL	aH	bL	bH

Range:

(pL + pH × 256) = 5 (pL = 5, pH = 0)
m = 112
0 ≤ (aL + aH × 256) ≤ 65535 (0 ≤ aL ≤ 255, 0 ≤ aH ≤ 255)
0 ≤ (bL + bH × 256) ≤ 65535 (0 ≤ bL ≤ 255, 0 ≤ bH ≤ 255)

Default:

aL = 141, aH = 0 (BM height(top of a BM ~ bottom of BM): 20 mm)
bL = 20, bH = 11 (BM interval(top of a BM ~ top of next BM): 400 mm)

Description:

■ This command sets the black mark paper format.
- pL, pH specifies (pL + pH × 256) as the number of bytes after pH (m, aL, aH,bL, bH).
- aL, aH specifies [(aL + aH × 256) × vertical motion units] as the BM height.
- bL, bH specifies as [(bL + bH × 256) × vertical motion units] as the BM interval.

Remarks:

■ The available BM height ranges from 4 to 20 mm.
■ If the BM height specified is out of range, this command is ignored.
■ The BM interval ranges from 40 to 400 mm.
■ If the BM interval specified is out of range, this command is ignored.

Differences:

None

GS (N

Function: **Select character color**

Code:

ASCII	GS	(	N	pL	pH	n	m
Hex	1D	28	4E	pL	pH	n	m
Decimal	29	40	78	pL	pH	n	m

Range:
(pL + pH x 256) = 2 (pL=2, pH=0)
n=48
m=49 (when the monochrome paper is selected)
m=49,50 (when the two-color paper is selected)

Default: m=49

Printers: **SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN**

Description:
■ This command selects the color specified by m.

m	**Color**
49	Color 1
50	Color 2

• Color 1 means black and Color 2 red.

Remarks:
■ In white/black reverse mode, the characters are regarded as nonprinting dots and the background is printed in the color specified by this command.
■ In underline mode, the underline is printed in the color defined by this command.

Differences: None

GS (k

Function: **Specify and print the symbol**

Code: None

Range: None

Default: None

Printers:
■ **SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
Supporting Function 065 – Function 182
■ **SPP-R200:**
Supporting Function 065 – Function 381

Description:
■ This command processes the data concerning two-dimensional code.
- Symbol type is specified by cn.
- Function code is specified by fn.

cn	Type of Symbol
48	PDF417 (2-dimensional code)
49	QR CODE (2-dimensional code)
50	MAXI CODE(2-dimensional code)
51	DATAMATRIX(2-dimensional code)

cn	fn	Function	
48	65	Function 065	PDF417: Specify the number of columns
	66	Function 066	PDF417: Specify the number of rows
	67	Function 067	PDF417: Specify the width of module
	68	Function 068	PDF417: Specify the module height
	69	Function 069	PDF417: Specify the error correction level
	70	Function 070	PDF417: Specify the option
	80	Function 080	PDF417: Store the received data in the symbol storage area
	81	Function 081	PDF417: Print the symbol data in the symbol storage area
	82	Function 082	PDF417: Send the size information of the symbol data in the symbol storage area
49	65	Function 165	QR CODE: Select the module
	67	Function 167	QR CODE: Select the size of module
	69	Function 169	QR CODE: Select the error correction level
	80	Function 180	QR CODE: Store the data in the symbol storage area
	81	Function 181	QR CODE: Print the data in the symbol storage area
	82	Function 182	QR CODE: Transmit the size information of the symbol data in the symbol storage area
50	65	Function 265	MAXI CODE: Select the mode
	80	Function 280	MAXI CODE: Store the data in the symbol storage area
	81	Function 281	MAXI CODE: Print the symbol data saved in The symbol storage area
51	67	Function 367	DATAMATRIX: Select the size of module
	80	Function 380	DATAMATRIX: Store the symbol data in the symbol storage area
	81	Function 381	DATAMATRIX: Print the symbol data in the storage area

Remarks: PDF417 symbol data (when cn=48)

- The symbol data is defined, stored to the symbol storage area by Function 080 and printed by the specification of Function 081. The symbol data in the area remains reserved until the following processes are executed:
  - Performing Function 080
  - Performing ESC @
  - Performing the printer reset and power-off
- The setting values of Functions 065 to 070 are utilized for the processing of Function 080 or 082. The printable area must be large enough to accommodate different-size symbols. If not, the symbol may not be printed.
- The same symbol data is repeatedly printed by executing Function 081 after performing Function 080.
- The same symbol data is printed differently by executing Function 081 after setting the feature of the symbol by using Functions 065 through 070.
- By using Function 082, the symbol size printed by Function 081 is Available.

QRCODE Symbol Data (cn = 49)

- The symbol data is defined, stored to the symbol storage area by Function 180 and printed by the specification of Function 181. The symbol data in the area remains reserved until the following processes are executed:
  - Performing Function 180
  - Performing ESC @
  - Performing the printer reset and power-off
- The setting values of Functions 165 to 169 are utilized for the processing of Function 180 or 182. The printable area must be large enough to accommodate different-size symbols. If not, the symbol may not be printed.
- The same symbol data is repeatedly printed by executing Function 181 after performing Function 180.
- The same symbol data is printed differently by executing Function 181 after setting the feature of the symbol by using Functions 165 through 169.
- By using Function 182, the symbol size printed by Function 181 is available.

MAXI CODE Symbol Data (cn = 50)

- The symbol data is defined, stored to the symbol storage area by Function 280 and printed by the specification of Function 281. The symbol data in the area remains reserved until the following processes are executed:
  - Performing Function 280
  - Performing ESC @
  - Performing the printer reset and power-off
- The setting value of Functions 265 is utilized for the processing of Function 281. The printable area must be large enough to accommodate different-size symbols. If not, the symbol may not be printed.

- The same symbol data is repeatedly printed by executing Function 281 after performing Function 280.
- The same symbol data is printed differently by executing Function 281 after setting the mode by using Functions 265.

DATAMATRIX Symbol Data (cn=51)

- The symbol data is defined, stored to the symbol storage area by Function 380 and printed by the specification of Function 381. The symbol data in the area remains reserved until the following processes are executed:
  - Performing Function 380
  - Performing ESC @
  - Performing the printer reset and power-off
- The setting value of Functions 367 is utilized for the processing of Function 381. The printable area must be large enough to accommodate different-size symbols. If not, the symbol may not be printed.
- The same symbol data is repeatedly printed by executing Function 381 after performing Function 380.
- The same symbol data is printed differently by executing Function 381 after setting the mode by using Functions 367.

Differences: None

<Function 065> GS (k pL pH cn fn n (fn=65)

Code:

ASCII	GS	(	k	pL	pH	cn	fn	n
Hex	1D	28	6B	03	00	30	41	n
Decimal	29	40	107	3	0	48	65	n

Range:

(pL + pH x 256) = 3 (pL=3, pH=0)
cn=48, fn=65
0 ≤ n ≤ 30

Default:

n=0

Description:

■ This command specifies the number of columns in the data area of PDF417.
- When n=0, automatic processing is set
- When n is not 0, the number of columns of the data area is set to n code word.

Remarks:

■ Settings of this command affect the processing of Functions 081 and 082.
■ With auto processing (n=0) specified, the maximum number of columns in the data area is set to 30 columns.
■ The following data is excluded from the number of columns:
- Start and stop patterns
- Indicator code word of left and right

■ With auto processing (n=0) specified, the number of columns is calculated using the following information.
- Printing area when processing Functions 081, 082
- Module width (Function 067)
- Option setting (Function 070)

■ The setting of this command remains effective until ESC @, printer reset or power cycling is executed.

Differences:

None

<Function 066> GS (k pL pH cn fn n (fn=66)

Code:

ASCII	GS	(	k	pL	pH	cn	fn	n
Hex	1D	28	6B	03	00	30	42	n
Decimal	29	40	107	3	0	48	66	n

Range:

(pL + pH x 256) = 3 (pL=3, pH=0)
cn=48, fn=66
n=0, 3 ≤ n ≤ 90

Default:

n=0

Description:

■ This command specifies the number of rows in the data area of PDF417.
- When n=0, automatic processing is set
- When n is not 0, the number of rows is set to n rows.

Remarks:

■ Settings of this function affect the processing of Functions 081 and 082.
■ With auto processing (n=0) specified, the maximum number of rows is set to 90.
■ With auto processing (n=0) specified, the number of rows is calculated by using the following information:
- Printing area when processing Functions 081, 082
- Module height (Function 068)

■ The setting of this command remains effective until ESC @, printer reset or power cycling is executed.

Differences:

None

<Function 067> GS (k pL pH cn fn n (fn=67)

Code:

ASCII	GS	(	k	pL	pH	cn	fn	n
Hex	1D	28	6B	03	00	30	43	n
Decimal	29	40	107	3	0	48	67	n

Range:

(pL + pH x 256) = 3 (pL=3, pH=0)
cn=48
fn=67
2 ≤ n ≤ 3

■ **SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
1 ≤ n ≤ 4

Default:

n=3

Description:

This command sets the width of the module of PDF417 symbol to n dots.

Remarks:

■ Settings of this command affect the processing of Functions 081 and 082.
■ The setting unit for printer models varies.
■ The setting of this command remains effective until ESC @, printer reset or power cycling is executed.

Differences:

■ Setting unit(1 dot)
- **SRP-350, SRP-350plus, SRP-350plusN, SRP-350plusV, SRP-350plusM:**
  0.141(1/180 inch)
- **SRP-352plus, SRP-352plusN:**
  0.125(1/203 inch)
- **SPP-R200:**
  0,125 mm(1/203 inch)

<Function 068> GS (k pL pH cn fn n (fn=68)

Code:

ASCII	GS	(	k	pL	pH	cn	fn	n
Hex	1D	28	6B	03	00	30	44	n
Decimal	29	40	107	3	0	48	68	n

Range:

(pL + pH x 256) = 3 (pL=3, pH=0)
cn=48
fn=68
2 ≤ n ≤ 8

Default:

n=3

Description:

This command sets the module height of PDF417 to [the module width x n]

Remarks:

- Settings of this command affect the processing of Functions 081 and 082.
- The setting of this command remains effective until ESC @, printer reset or power cycling is executed.

Differences:

None

<Function 069> GS (k pL pH cn fn m n (fn=69)

Code:

ASCII	GS	(	k	pL	pH	Cn	fn	m	n
Hex	1D	28	6B	04	00	30	45	m	n
Decimal	29	40	107	4	0	48	69	m	n

Range:

(pL + pH x 256) = 4 (pL=4, pH=0)
cn=48
fn=69
m=48
48 ≤ n ≤ 56
■ **SPP-R200:**
0≤n≤8

Default: None

Description:

■ This command specifies the error correction level for PDF417.
  • The error correction level is set by “level”

Remarks:

■ Settings of this function affect the processing of Functions 081 and 082.

■ Error correction level specified by “level” (m=48) is as follows:
The number of the error correction codeword is unchanged regardless of the number of codeword in the data area.

n	Function	Number of error correction codeword
48	Error correction level 0	2
49	Error correction level 1	4
50	Error correction level 2	8
51	Error correction level 3	16
52	Error correction level 4	32
53	Error correction level 5	64
54	Error correction level 6	128
55	Error correction level 7	256
56	Error correction level 8	512

■ The setting of this command remains effective until ESC @, printer reset or power cycling is executed.

Differences: None

<Function 070> GS (k pL pH cn fn m (fn=70)

Code:

ASCII	GS	(	k	pL	pH	cn	fn	m
Hex	1D	28	6B	03	00	30	46	m
Decimal	29	40	107	3	0	48	70	m

Range:

(pL + pH x 256) = 3 (pL=3, pH=0)
cn=48
fn=70
m=0,1

Default:

m=0

Description:

This command selects the option for PDF417.

m	Function
0	Select the standard PDF417
1	Select the simplified PDF417

Remarks:

- Settings of this function affect the processing of Functions 081 and 082.
- When simplified PDF417 symbol is canceled, standard PDF417 symbol is automatically selected.
- The setting of this command remains effective until ESC @, printer reset or power cycling is executed.

Differences:

None

<Function 080> GS (k pL pH cn fn m d1...dk (fn=80)

Code:

ASCII	GS	(	k	pL	pH	cn	fn	m	d1...dk
Hex	1D	28	6B	pL	pH	30	50	30	d1...dk
Decimal	29	40	107	pL	pH	48	80	48	d1...dk

Range:

4 ≤ (pL + pH x 256) ≤ 65535 (0 ≤ pL ≤ 255, 0 ≤ pH ≤ 255)
cn=48
fn=80
m=48
0 ≤ d ≤ 255
k = (pL + pH x 256) – 3

Default: None

Description: This command stores the PDF417 symbol data (d1...dk) in the symbol storage area.

Remarks:

- The data stored in the symbol storage area by this command remains reserved after processing Function 081 or 082.
- The following data should not be included in the symbol data d1..dk since this information is automatically added by the printer:
  - Start pattern and stop pattern.
  - Indicator codeword of left and right.
  - The descriptor of symbol length. (the first code word in the data area)
  - The error correction codeword calculated by modulus 929.
- The setting of this command remains effective until the following processing is performed:
  - Executing Function 080
  - Executing ESC @
  - Executing printer reset or power-off

Differences: None

<Function 081> GS (k pL pH cn fn m (fn=81)

Code:

ASCII	GS	(	k	pL	pH	cn	fn	m
Hex	1D	28	6B	03	00	30	51	m
Decimal	29	40	107	3	0	48	81	m

Range:

(pL + pH x 256) = 3 (pL=3, pH=0)
cn=48
fn=81
m=48

Default:

None

Description:

This command encodes and prints the PDF417 symbol data in the symbol save area.

Remarks:

- In standard mode, this command is available only when printer is at the beginning of a line or the printer buffer is empty.
- A symbol exceeding the printing area in size can not be printed.
- Printing operation is not processed under the following conditions:
  - There is no data (Function 080 is not processed).
  - If [(number of columns x number of rows) < number of code word] when automatic processing is specified for number of columns and number of rows.
  - Number of code word exceeds 928 in the data area.
- The following data is added automatically by the encode processing:
  - Start pattern and stop pattern.
  - Indicator code word of left and right.
  - The descriptor of symbol length. (the first code word in the data area)
  - The error correction code word calculated by modulus 929.
  - Pad codeword.

■ The data area includes the following codewords:
  • Data specified by Function 080.
  • The descriptor of symbol length. (the first code word in the data area)
  • The error correction code word calculated by modulus 929.
  • Pad codeword.
■ When automatic processing (Function 065) is specified, the number of columns is calculated using the following information:
  • Current printing area
  • Module width (Function 067)
  • Option setting (Function 070)
  • Codeword in the data area
  • The maximum number of columns is 30.
■ When auto processing (Function 066) is specified in page mode, the number of rows is calculated using the following information:
  • Current printing area
  • Module height (Function 068)
  • Codeword in the data area
  • The maximum number of rows is 90.
■ Except for character size and upside-down printing mode, none of print mode such as emphasized, double-strike, etc, affects the printing of the symbol.
■ In standard mode, the paper feed amount set by the paper feed setting command does not affect printing of the symbol. The printing position returns to the left side of the printable area after printing the symbol.
■ In page mode, the printer stores the symbol data in the print buffer without executing actual printing.
■ The quiet zone is not included in the printing data. Be sure to include the adequate quiet zone for executing of this command.
  • The quiet zone means the spaces surrounding the symbol such as upper, lower, left, and right spaces.

Differences: None

<Function 082> GS (k pL pH cn fn m (fn=82)

Code:

ASCII	GS	(	k	pL	pH	cn	fn	m
Hex	1D	28	6B	03	00	30	52	m
Decimal	29	40	107	3	0	48	82	m

Range:

(pL + pH x 256) = 3 (pL=3, pH=0)
cn=48
fn=82
m=48

Default:

None

Description:

This command encodes and sends the size information of the PDF417 symbol data in the symbol storage area.

Remarks:

■ In standard mode, this command is available only when printer is at the beginning of a line or the printer buffer is empty.

■ The size information for each data is as follows:

Send data	Hex	Decimal	Data
Header	37H	55	1 byte
Identifier	2FH	47	1 byte
Horizontal size	30H – 39H	48 – 57	1 – 5 byte
Separator	1FH	31	1 byte
Vertical size	30H – 39H	48 – 57	1 – 5 byte
Separator	1FH	31	1 byte
Fixed value	31H	49	1 byte
Separator	1FH	31	1 byte
Other information	30H or 31H	48 or 49	1 byte
NUL	00H	0	1 byte

• Horizontal size and vertical size denotes the number of dots of the symbol.

■ The following data indicates whether or not printing of the symbol is possible:

Hex	Decimal	Condition
30H	48	Printing is possible
31H	49	Printing is impossible

■ The quiet zone is not included in the printing data. Be sure to include the adequate quiet zone for executing of this command.

Differences: None

<Function 165> GS (k pL pH cn fn n1 n2 (fn=65)

Code:

ASCII	GS	(	k	pL	pH	cn	fn	n1	n2
Hex	1D	28	6B	04	00	31	41	n1	n2
Decimal	29	40	107	4	0	49	65	n1	n2

Range:

(pL + pH x 256) = 3 (pL=3, pH=0)
cn=49
fn=65
n1 = 49, 50
n2 =0

Default:

n1=50, n2 =0

Description:

This command sets the QR Code model as follows:

n1	Function
49	Model 1
50	Model 2

Remarks:

- The setting of this command affects <Function 181> and <Function 182>.
- The setting of this command remains effective until ESC @, printer reset or power cycling is executed.

Differences:

None

<Function 167> GS (k pL pH cn n (fn=67)

Code:

ASCII	GS	(	k	pL	pH	cn	fn	n
Hex	1D	28	6B	03	00	31	43	n
Decimal	29	40	107	3	0	49	67	n

Range:

(pL + pH x 256) = 3 (pL=3, pH=0)
cn=49
fn=67
0<=n<9

■ **SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
1<=n<8

Default:

n=3

Description:

This command sets the size of the QR Code module to n dots.

Remarks:

■ The setting of this command affects the processing of <Function 181> and <Function 182>.
■ Since the QR CODE module is square, n = module width = module height
■ The setting of this command remains effective until ESC @, printer reset or power cycling is executed.

Differences:

None

<Function 169> GS (k pL pH cn n (fn=69)

Code:

ASCII	GS	(	k	pL	pH	cn	fn	n
Hex	1D	28	6B	03	00	31	45	n
Decimal	29	40	107	3	0	49	69	n

Range:

(pL + pH x 256) = 3 (pL=3, pH=0)
cn=49
fn=69
48≤n≤51

Default:

n=48

Description:

This command sets the error correction level for QR Code.

n	Function	Recovery Amount (%)
48	Error Correction Level L	7
49	Error Correction Level M	15
50	Error Correction Level Q	25
51	Error Correction Level H	30

Remarks:

- The setting of this command affects the processing of <Function 181> and <Function 182>.
- Reed-Solomon correction is employed to generate a series of error correction codewords.
- The setting of this command remains effective until ESC @, printer reset or power cycling is executed.

Differences:

None

<Function 180> GS (k pL pH cn fn m d1...dk (fn=80)

Code:

ASCII	GS	(	k	pL	pH	cn	fn	m	d1...dk
Hex	1D	28	6B	pL	pH	31	50	30	d1...dk
Decimal	29	40	107	pL	pH	49	80	48	d1...dk

Range:

4 ≤ (pL + pH x 256) ≤7092 (0 ≤ pL ≤ 255, 0 ≤ pH ≤ 27)
cn=49
fn=80
m=48
0 ≤ d ≤ 255
k = (pL + pH x 256) – 3

Default: None

Description: This command saves symbol data of the QR Code to the symbol storage area.

Remarks:

■ The symbol data is defined, stored to the symbol storage area by Function 180 and printed by the specification of Function 181. The data remains reserved after completion of printing.

■ The following shows the data available for encoding of QR code.

Character Type	Usable Characters
Numeric Data	“0” ~ “9”
Alphanumeric Data	“0” ~ “9”, “A” ~ “Z”, SP, $, %, *, +, -, ., /, :
Kanji Data	Shift JIS value
8bit Byte Data	00H ~ FFH

■ The setting of this command remains effective until the following processing is performed:
- Performing Function 180
- Performing ESC @
- Performing the printer reset or power-off

Differences: None

<Function 181> GS (k pL pH cn fn m (fn=81)

Code:

ASCII	GS	(	k	pL	pH	cn	fn	m
Hex	1D	28	6B	03	00	31	51	m
Decimal	29	40	107	3	0	49	81	m

Range:

(pL + pH x 256) = 3 (pL=3, pH=0)
cn=49
fn=81
m=48

Default:

None

Description:

This command encodes and prints QR Code symbol data saved in the symbol storage area.

Remarks:

■ In standard mode, this command is available only when printer is at the beginning of a line or the printer buffer is empty.
■ A symbol exceeding the printing area in size can not be printed.
■ Printing operation is not processed under the following conditions:
  • There is no data. (Function 180 is not executed)
  • If [(number of columns x number of rows) < number of code words], the numbers of columns and rows are automatically processed.
  • The four types of data compression modes are listed below. According to the symbol data in the data storage area, automatically selects the best suitable compression mode.
    *Numeric Data Code
    *Alphanumeric Data mode
    *Kanji Data mode
    *8 bit Data mode

■ The following data is automatically added by the encoding processing:
- Position sensor pattern
- Segregator for the position sensor pattern
- Timing pattern
- Format information
- Version information
- Error correction code text
- Pad code text
- Indicator for counting bits of bytes
- Mode indicator
- Concluder
- Queue pattern (when model 2 is selected)
- Expansion pattern (when model 1 is selected)

■ Except for character size and upside-down printing mode, none of print mode such as emphasized, double-strike, etc, affects the printing of the symbol.

■ In standard mode, the paper feed amount set by the paper feed setting command does not affect printing of the symbol. The printing position returns to the left side of the printable area after printing the symbol.

■ In page mode, the printer stores the symbol data in the print buffer without executing actual printing.

■ The quiet zone is not included in the printing data. Be sure to include the adequate quiet zone for executing of this command.

Differences: None

<Function 182> GS (k pL pH cn fn m (fn=82)

Code:

ASCII	GS	(	k	pL	pH	cn	fn	m
Hex	1D	28	6B	03	00	31	52	m
Decimal	29	40	107	3	0	49	82	m

Range:

(pL + pH x 256) = 3 (pL=3, pH=0)
cn=49
fn=82
m=48

Default:

None

Description:

This command transmits the size information of the QR Code symbol data encoded by Function 180.

Remarks:

■ In standard mode, this command is available only when printer is at the beginning of a line or the printer buffer is empty.

■ The size information of each data is as follows:

Send data	Hex	Decimal	Data
Header	37H	55	1 byte
Flag	36H	54	1 byte
Horizontal size	30H – 39H	48 – 57	1 – 5 byte
Separator	1FH	31	1 byte
Vertical size	30H – 39H	48 – 57	1 – 5 byte
Separator	1FH	31	1 byte
Fixed Value	31H	49	1 byte
Separator	1FH	31	1 byte
Other Information	30H or 31H	48 or 49	1 byte
NUL	00H	0	1 byte

• Horizontal size and vertical size denotes the number of dots of the symbol.

■ The following data indicates whether or not printing of the symbol is possible:

Hex	Decimal	Condition
30H	48	Printing is possible
31H	49	Printing is impossible

■ The quiet zone is not included in size information.

Differences: None

<Function 265> GS (k pL pH cn fn n1 n2 (fn=65)

Code:

ASCII	GS	(	k	pL	pH	cn	fn	n
Hex	1D	28	6B	03	00	32	41	n
Decimal	29	40	107	3	0	50	65	n

Range:

(pL + pH x 256) = 3 (pL=3, pH=0)
cn=50
fn=65
50 ≤ n ≤ 52

Default:

n = 50

Description:

This command selects the mode for Maxi Code

n	Function
50	Mode 2 Setting
51	Mode 3 Setting
52	Mode 4 Setting

Remarks:

- The setting of this command affects <Function 281> and <Function 282>.
- The setting of this command remains effective until ESC @, printer reset or power cycling is executed.

Differences:

None

<Function 280> GS (k pL pH cn fn m d1...dk (fn=80)

Code:

ASCII	GS	(	k	pL	pH	cn	fn	m	d1...dk
Hex	1D	28	6B	pL	pH	32	50	30	d1...dk
Decimal	29	40	107	pL	pH	50	80	48	d1...dk

Range:

4 ≤ (pL + pH x 256) ≤ 141 (4 ≤ pL ≤141, 0 ≤ pH ≤0)
cn=50
fn=80
m=48
0 ≤ d ≤ 255
k = (pL + pH x 256) – 3

Default: None

Description: This command stores Maxi Code symbol data in the symbol storage area.

Remarks:

- The data stored in the symbol storage area by this command is processed by Functions 281 and 282. The data remains reserved in the storage.
- The setting of this command remains effective until the following processing is performed:
  - Performing Function 280
  - Performing ESC @
  - Performing the printer reset or power-off

Differences: None

<Function 281> GS (k pL pH cn fn m (fn=81)

Code:

ASCII	GS	(	k	pL	pH	cn	fn	m
Hex	1D	28	6B	03	00	32	51	m
Decimal	29	40	107	3	0	50	81	m

Range:

(pL + pH x 256) = 3 (pL=3, pH=0)
cn=50
fn=81
m=48

Default:

None

Description:

This command encodes and prints Maxi Code symbol data saved in the storage area.

Remarks:

- In standard mode, this command is available only when printer is at the beginning of a line or the printer buffer is empty.
- A symbol exceeding the printing area in size can not be printed.
- Printing operation is not processed under the following conditions:
  - There is no data. (Function 280 is not executed)
  - The number of numeric characters exceeds 138
  - The number of alphanumeric characters exceeds 93
  - When mode 2 is selected, the primary message does not include all of the following:

Primary Message	Data Number	Character
Postal code	1~9	Numeric
ISO country code	1~3	Numeric
Service type code	1~3	Numeric

• When mode 3 is selected, the primary message does not include all of the following:

Primary Message	Data Number	Character
Postal code	1~6	Setting Code A
ISO country code	1~3	Numeric
Service type code	1~3	Numeric

■ Modes 2 and 3 are executed according to the following procedures:
(RS, GS indicates the control code of MAXI CODE. y indicates the 2-byte numeric data.)

a) 9-byte data including ” [)>”,”RS”,”01”,”GS”,”yy” are regarded as the Header.
  • The next data following the Header is the Primary Message.
  • When printing, the Header is placed at the beginning of the Secondary Message.

b) When Header data is absent, the data is regarded as Primary Message.

c) In the Primary Message, GS is used as the separator that divides message into Postal code, ISO country code, and Class of service. This GS is ignored.

d) All data of the Secondary Message is regarded as symbol data.

■ In mode 4, 5, 6, all of the data in the symbol storage area is regarded as Primary Message and Secondary Message.

■ For error correction codeword, the Reed-Solomon algorithm is employed.

■ The following data is automatically added during the encoding process:
  • Position sensor pattern
  • Position pattern
  • Error correction code text
  • Mode separator
  • Pad code text

■ In standard mode, the paper feed amount set by the paper feed setting command does not affect printing of the symbol. The printing position returns to the left side of the printable area after printing the symbol.

■ In page mode, the printer stores the symbol data in the print buffer without executing actual printing.

■ The quiet zone is not included in the printing data. Be sure to include the adequate quiet zone for executing of this command.

Differences: None

<Function 367> GS (k pL pH cn n (fn=67)

Code:

ASCII	GS	(	k	pL	pH	cn	fn	n
Hex	1D	28	6B	03	00	33	43	n
Decimal	29	40	107	3	0	51	67	n

Range:

(pL + pH x 256) = 3 (pL=3, pH=0)
cn=51
fn=67
2 ≤ n ≤ 3

Default:

n=3

Description:

This command sets the DATAMATRIX Code size.

Remarks:

- This command affects the execution of <Function 381>.
- The setting of this command remains effective until ESC @, printer reset or power cycling is executed.
- Since the DATAMATRIX Code module is square, n = module width = module height.

Differences:

None

<Function 380> GS (k pL pH cn fn m d1...dk (fn=80)

Code:

ASCII	GS	(	k	pL	pH	cn	fn	m	d1...dk
Hex	1D	28	6B	pL	pH	32	50	30	d1...dk
Decimal	29	40	107	pL	pH	50	80	48	d1...dk

Range:

0 ≤ (pL + pH x 256) ≤ 3116 (0≤ pL ≤255, 0 ≤ pH ≤13)
cn=50
fn=80
m=48
0 ≤ d ≤ 255
k = (pL + pH x 256) – 3

Default: None

Description: This command stores DATAMATRIX symbol data in the symbol storage area.

Remarks:

- The data stored to the symbol storage area by this command is executed by Function 381. The data remains reserved in the symbol storage area.
- The setting of this command remains effective until the following processing is performed:
  - Performing Function 380
  - Performing ESC @
  - Performing the printer reset or power-off

Differences: None

<Function 381> GS (k pL pH cn fn m (fn=81)

Code:

ASCII	GS	(	k	pL	pH	cn	fn	m
Hex	1D	28	6B	03	00	33	51	m
Decimal	29	40	107	3	0	51	81	m

Range:

pL + pH x 256) = 3 (pL=3, pH=0)
cn=51
fn=81
m=48

Default:

None

Description:

This command encodes and prints DATAMATRIX symbol data saved in the storage area.

Remarks:

- In standard mode, this command is available only when printer is at the beginning of a line or the printer buffer is empty.
- A symbol exceeding the printing area in size can not be printed.
- Printing operation is not processed under the following conditions:
  - There is no data. (Function 380 cannot be executed)
  - The number of alphanumeric characters exceeds 2334.
  - The number of 8bit byte characters exceeds 1558.
  - The number of numeric characters exceeds 3116.
- DATAMATRIX uses ECC 200 symbols.
- For error correction codeword, the Reed-Solomon algorithm is employed.
- The following data is automatically added during the encoding process:
  - Position pattern
  - Error correction code text
  - Mode separator
  - Pad code text

- In standard mode, the paper feed amount set by the paper feed setting command does not affect printing of the symbol. The printing position returns to the left side of the printable area after printing the symbol.
- In page mode, the printer stores the symbol data in the print buffer without executing actual printing.
- The quiet zone is not included in the printing data. Be sure to include the adequate quiet zone for executing of this command.

Differences: None

GS *

Function: **Define downloaded bit image**

Code:

ASCII	GS	*	x	y	[d1...d(x x y x 8)]
Hex	1D	2A	x	y	[d1...d(x x y x 8)]
Decimal	29	42	x	y	[d1...d(x x y x 8)]

Range:
1 ≤ x ≤ 255
1 ≤ y ≤ 48 (where x x y ≤ 1536)
0 ≤ d ≤ 255

Default: None

Printers: **STP-103, STP-131, SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM**

Description:
- This command defines the downloaded bit image using the number of dots specified by x and y.
  - x and y specify the number of dots in the horizontal and vertical directions respectively.
  - D defines the bit image data.
  - K denotes the number of the definition data.

Remarks:
- The bit image can be printed by downloaded graphics function, BS ^ 7.
- The downloaded bit image is available until ESC @, printer reset or power cycling is executed.
- The user-defined character and the downloaded bit image cannot be defined simultaneously.
  - The user-defined character is cleared preceding the execution of this command.
  - The downloaded bit image data is cleared with ESC & executed.

Differences: None

GS /

Function: **Print downloaded bit image**

Code:

ASCII	GS	/	m
Hex	1D	2F	m
Decimal	29	47	m

Range: 0 ≤ m ≤ 3, 48 ≤ m ≤ 51

Default: None

Printers: **STP-103, STP-131, SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM**

Description: This command prints the downloaded bit image defined by GS * according to the mode denoted by m.

DPI : Dots per Inch (25.4mm)

m	Mode	Vertical dot density(DPI)	Horizontal dot density(DPI)
0, 48	Normal	180	180
1, 49	Double-width	180	90
2, 50	Double-height	90	180
3, 51	Quadruple	90	90

Remarks:

- The download bit image is defined by GS *.
- This command is ignored when if a downloaded bit image is not defined.
- In standard mode, this command works only when the print buffer is empty and the printer is in the start of the line. m is treated as normal data if the print buffer has data.
- In page mode, the bit image data is accumulated in the print buffer, but does not perform the actual printing.
- Except for character size and upside-down printing mode, none of print mode such as emphasized, double-strike, etc, affects the printing of the downloaded bit image.
- The default dot density set by GS L is applied to printing of the downloaded bit image.

Differences: ■ **STP-103, SRP-352plus, SRP-352plusN:**

DPI : Dots per Inch (25.4mm)

m	Mode	Vertical dot density(DPI)	Horizontal dot density(DPI)
0, 48	Normal	203	203
1, 49	Double-width	203	203/2
2, 50	Double-height	203/2	203
3, 51	Quadruple	203/2	203/2

■ **STP-131, SRP-350, SRP-350plus, SRP-350plusN, SRP-350plusV, SRP-350plusM:**

DPI : Dots per Inch (25.4mm)

m	Mode	Vertical dot density(DPI)	Horizontal dot density(DPI)
0, 48	Normal	180	180
1, 49	Double-width	180	90
2, 50	Double-height	90	180
3, 51	Quadruple	90	90

GS :

Function: **Start/end macro definition**

Code:

ASCII	GS	:
Hex	1D	3A
Decimal	29	58

Range: None

Default: None

Printers: **STP-103, STP-131, SPP-R200, SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM**

Description:
- This command starts or ends macro definition.

Remarks:
- The printer starts macro definition during normal operation and finishes it during macro definition upon receiving this command.
- The printer performs printing during macro definition.
- The macro is executed by GS ^.
- The maximum number of macro data to be defined varies with respect to printer models. The data exceeding this limit is not stored.
- ESC @ does not clear the existing defined macro. The macro remains effective until the printer reset and power cycling are executed.

Differences: The maximum number of macro data to be defined.

- **SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
  2048 byte

GS <

Function: **Black mark initialization**

Code:

ASCII	GS	<
Hex	1D	3C
Decimal	29	60

Range: None

Default: None

Printers: **SRP-350plusV, SRP-350plusM**

Description:
- This command performs the black mark initialization.

Remarks:
- This command initializes the values specified by the black mark control command GS (F.
  - Printing starting position, paper cutting position, black mark paper format.
- The initialized values are the same as the ones that are set when the power is turned on.

Differences: None

GS B

Function: **Turns white/black reverse printing mode on / off**

Code:

ASCII	GS	B	n
Hex	1D	42	n
Decimal	29	66	n

Range: 0 ≤ n ≤ 255

Default: n=0

Printers: **STP-103, STP-131, SPP-R200, SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM**

Description:
- This command selects white/black reverse printing mode by setting the least significant bit of n.
  - When the LSB of n is 0, white/black reverse mode is turned off.
  - When the LSB of n is 1, white/black reverse mode is turned on.

Remarks:
- This command does not affect multi-byte characters such as Kanji, Japanese and Korean.
- The right space defined by ESC SP is affected by this command.
- In white/black reverse mode, the underline mode is not effective.
- This mode remains effective until ESC @, printer reset or power cycling is executed.

Differences: None

GS H

Function: **Selects print position of HRI characters**

Code:

ASCII	GS	H	n
Hex	1D	48	n
Decimal	29	72	n

Range: 0 ≤ n ≤ 3, 48 ≤ n ≤ 51

Default: n=0

Printers: **STP-103, STP-131, SPP-R200, SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM**

Description:

■ This command selects the printing position of HRI (Human Readable Interpretation) characters when printing a bar code.

• The printing position is set according to the value of as follows:

n	Printing position
0, 48	Not printed
1, 49	Above the bar code
2, 50	Below the bar code
3, 51	Both above and below the bar code

Remarks:

■ The font of the HRI characters is defined by GS f.

■ The setting of this command remains effective until ESC @, printer reset or power cycling is executed.

Differences: None

GS I

Function: **Transmits printer ID**

Code:

ASCII	GS	I	n
Hex	1D	49	n
Decimal	29	73	n

Range: 1 ≤ n ≤ 69

Default: None

Printers: **All printer models**

Description: ■ This command transmits the printer ID or information.

• Transmits 1 byte of printer ID, using n as follows:

n	Printer ID	Specification
1,49	Printer model ID	Printer model
2,50	Type ID	Printer type
3,51	Printer feature ID	Printing method and Printer size

• Transmits specified printer information, using n as follows:

n	Printer ID type	Specification
65	Firmware version	Firmware version
66	Manufacturer	BIXOLON
67	Printer model	Printer model
69	Code page	Currently enabled code page

Remarks: ■ Printer information (When n = 65, 66, 67, 69) consist of [Header ~ NULL] data as shown below:

Transmitted data	Hex	Decimal	Amount of data
Header	5FH	95	1byte
Printer information	Depends on the model	Depends on the model	0-15 bytes
NUL	00H	0	1byte

■ The firmware version can be confirmed by self test printing.

■ This command can be executed in real-time command mode using DLE.

Differences:

■ The printer ID is shown according to printer models as follows:

Printer ID	STP-103	STP-131	SRP-270	SRP-500	SRP-350	SRP-275	SRP-350plus	SPP-R200	SRP-280
1(Printer model ID)	0x40	0x20	0x0d	0x0d	0x20	0x0d	0x20	0x41	0d
2(Type ID)	Type ID varies depending on functions the printer supports as follows: - 0x01 (Multi-byte character) - 0x02 (Autocutter) - 0x03 (Autocutter + Multi-byte character) - 0x04 (Customer display) - 0x05 (Multi-byte character + Display) - 0x07 (Customer display + Autocutter + Multi-byte Character)								
3(Printer feature ID)	0x62	0x63	0x64	0x65	0x63	0x64	0x63	0x69	0x64
66(Manufacturer)	BIXOLON								
67(Printer model)	STP-103	STP-131	SRP-270	SRP-500	SRP-350	SRP-275	SRP-350plus	SPP-R200	SRP-280
69(Language of Font)	Code page currently being used. Refer to cod page setting command, ESC t.								

GS I b

Function: **Transmits battery status**

Code:

ASCII	GS	I	b
Hex	1D	49	62
Decimal	29	73	98

Range: None

Default: None

Printers: **SPP-R200**

Description:

■ This command transmits the battery power status of the printer.

• The printer transmits [Header ~ NUL] data as shown below:

Transmitted data	Hex	Decimal	Amount of data
Header	37H	55	1byte
Identifier	45H	69	1byte
Remaining battery power	30h-34H	48-52	1byte
NUL	00H	0	1byte

• “Remaining battery power“ is indicated as following:

Hex	Decimal	Remaining battery power level
30H	48	Full(F)
31H	49	High(H)
32H	50	Middle(M)
33H	51	Low(L)

Remarks:

■ The remaining battery amount can be examined by the battery LED.

■ When the remaining battery power reaches Low level, the red LED of battery starts blinking as an alert signal.

■ This command can be executed in real-time command mode using DLE.

Differences: None

GS L

Function: **Set left margin**

Code:

ASCII	GS	L	nL	nH
Hex	1D	4C	nL	nH
Decimal	29	76	nL	nH

Range: 0 ≤ nL ≤ 255, 0 ≤ nH ≤ 255

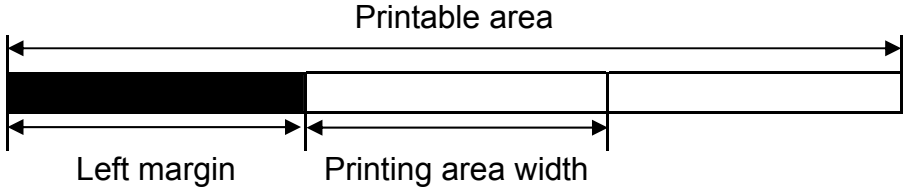
Default: (nL + nH x 256)=0 (nL=0, nH=0)

Printers: **STP-103, STP-131, SPP-R200, SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM**

Description: This command sets the left margin specified to [(nL + nH x 256) x (horizontal motion units)].

Remarks:

- The left margin is not effective in page mode. If the left margin is enabled in page mode, the setting is available when the printer returns to standard mode.
- When the setting is beyond the printable area, the left margin is automatically set to the maximum value of the printable area.
- Since the left margin is the same as the leftmost side of the printable area, the left side of the printable area is changed according to the left margin specified.
- The setting of this command remains effective until ESC @, printer reset or power cycling is executed.



Differences: None

GS T

Function: **Set print position to the beginning of print line**

Code:

ASCII	GS	T	n
Hex	1D	54	n
Decimal	29	84	n

Range: n=0, 1, 48, 49

Default: None

Printers: **SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM**

Description:

■ This command sets the print position to the beginning of the print line.

• n specifies how data in the print buffer is processed when this command is executed.

n	Function
0, 48	Sets the print position after the data in the print buffer is deleted.
1, 49	Sets the print position after the data in the print buffer is printed.

Remarks:

■ This command is effective only in standard mode, and ignored in page mode.

■ When n =1,49, the printer prints the data in the print buffer and executes a line feed, based on the line feed amount specified.

■ When n=0,48, the printer removes the print data in the print buffer.

■ After processing this command, the print position moves to the left of the print area. The printer buffer will be empty.

■ This command is ignored if the print position is already the begaining of the line.

Differences: None

GS V

Function: **Select cut mode and cut paper**

Code:

①	**ASCII**	GS	V	m	
	Hex	1D	56	m	
	Decimal	29	86	m	
②	**ASCII**	GS	V	m	n
	Hex	1D	56	m	n
	Decimal	29	86	m	n

Range: ① m=0, 1, 48, 49 ② m=65, 66, 0 ≤ n ≤ 255

Default: None

Printers: All printer models except for **STP-103, SPP-R200**

Description: This command cuts paper in the specified mode as follows.

m		Function
①	0,48	Executes a full cut (cuts the paper completely)
	1,49	Executes a partial cut (one point left uncut)
②	65	Feeds paper to (cutting position + n × vertical motion unit) and executes a partial cut(one point left uncut)
	66	Feeds paper to (cutting position + n × vertical motion unit) and executes a partial cut(one point left uncut)

Remarks: For ①

■ If an auto cutter is not provided, this command is ignored command is executed.

For ②

■ When n = 0, the printer feeds the paper to the cutting position and cuts it.
■ If an auto cutter is not provided, the printer only feeds the paper for specified amount.
■ Vertical motion unit is used for calculating a paper feed amount.

Differences:

■ **STP-131, SRP-350, SRP-350N:**
Only partial cut available

■ **SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**

m		Function
①	0,48	Executes a partial cut (one point left uncut)
	1,49	
②	65	Feeds paper to (cutting position + n × vertical motion unit) and executes a partial cut(one point left uncut)

■ Cutting mode is changed only by setting MSW2-2.

GS W

Function: **Set printing area width**

Code:

ASCII	GS	W	nL	nH
Hex	1D	57	nL	nH
Decimal	29	87	nL	nH

Range: 0 ≤ nL ≤ 255, 0 ≤ nH ≤ 255

Default:

- **STP-103, SPP-R200, SRP-350N:**
  (nL + nH x 256)=384 (nL=128, nH=1)
- **STP-131, SRP-350:**
  (nL + nH x 256)=512 (nL=0, nH=2) (When 80mm width of paper used)
  (nL + nH x 256)=384 (nL=128, nH=1) (When 60mm width of paper used)
  (nL + nH x 256)=360 (nL=104, nH=1) (When 58mm width of paper used)
- **SRP-350plus, SRP-350plusV, SRP-350plusM:**
  (nL + nH x 256)=512 (nL=0, nH=2) (When 80mm width of paper used)
- **SRP-350plusN:**
  (nL + nH x 256)=360 (nL=104, nH=1) (When 58mm width of paper used)
- **SRP-352plus:**
  (nL + nH x 256)=576 (nL=64, nH=2) (When 80mm width of paper used)
- **SRP-352plusN:**
  (nL + nH x 256)=384 (nL=128, nH=1) (When 60mm width of paper used)

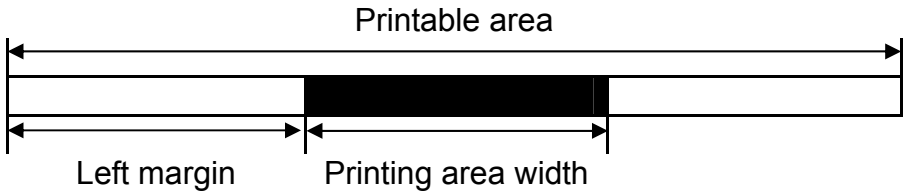
Printers: All printer models except for **SRP-270, SRP-275, SRP-280, SRP-500**

Description: This command sets the printing area width to [(nL + nH x 256) x (horizontal motion units)].

Remarks:

- The printing area width is not effective in page mode. If the printing area width is enabled in page mode, the setting is available when the printer returns to standard mode.
- When (left margin + printing area width) exceeds the printable area, the printing area width is automatically set to (printing area width - left margin).

■ The setting of this command remains effective until ESC @, printer reset or power cycling is executed.



Differences: None

GS \

Function: **Set relative vertical print position in page mode**

Code:

ASCII	GS	\	nL	nH
Hex	1D	5C	nL	nH
Decimal	29	92	nL	nH

Range: 0 ≤ nL ≤ 255, 0 ≤ nH ≤ 255

Default: None

Printers: All printer models except for for **STP-103, STP-131, SRP-270, SRP-275, SRP-280, SRP-500**

Description: This command moves the vertical print position to [(nL + nH x 256) x (vertical or horizontal motion units)] relative to the current position in page mode.

Remarks:
- This command is effective in page mode. When used in standard mode, it is ignored.
- The setting exceeding the print area set by ESC W is ignored.
- With standard mode selected, the vertical motion unit is used.
- In page mode, the horizontal motion unit is used when printing start poison is defined to the upper right or lower right of print area using ESC T, otherwise, the vertical motion unit is used.

Differences: None

GS ^

Function: **Execute macro**

Code:

ASCII	GS	^	r	t	m
Hex	1D	5E	r	t	m
Decimal	29	94	r	t	m

Range:
0 ≤ r ≤ 255
0 ≤ t ≤ 255
m=0, 1

Default: None

Printers: **STP-103, STP-131, SRP-350, SRP-350N, SRP-350plus, SRP-352plus, , SRP-350plusV, SRP-350plusM, SPP-R200**

Description:
■ This command executes a macro using parameters as following:
- r specifies the number of times to execute the macro.
- t specifies the waiting time before the macro is executed.
- m specifies macro executing mode as shown below.

m	Function
0	Executes the macro r times continuously at the interval specified by t.
1	The printer waits for the paper FEED button to be pressed for the time specified by t. The macro is executed once when the button is pressed. This operation is repeated r times.

Remarks:
■ The macro is defined by GS:.
■ If the macro is not defined or r = 0, the command is ignored.
■ The macro function is useful to print the same data repeatedly.

Differences: None

GS a

Function: **Enable/Disable Automatic Status Back (ASB)**

Code:

ASCII	GS	a	n
Hex	1D	61	n
Decimal	29	97	n

Range: 0 ≤ n ≤ 255

Default: n=0

Printers: All printer models except for **SPP-R200**

Description:
- This enables or disables ASB (Automatic Status Back) according to n.
  - ASB is enabled when n > 0.

Remarks:
- ASB is the function that transmit the printer status such as cover open/close and Online/Offline] continuously at the time interval specified regardless of the status change if ASB is enabled. Using this ASB function, the host can check to see if the printer is running properly.
- Once ASB has been enabled, the printer continues to transmit the current printer status at the specified interval until ASB is disabled.
- When n = 0, ASB is disabled. The printer stops transmitting the status.
- With parallel and USB interface, the printer status is transmitted whenever the host computer changes to the reverse mode regardless of the printer status change. It is recommended that the periodic time interval at which the host changes to reverse mode is more than 500ms in order to receive the correct status.
- With serial interface, ASB status is transmitted continuously at the interval of 1 sec even if the status is not changed.
- The setting of this command remains effective until ESC @, printer reset or power cycling is executed.

■ The printer information transmitted is comprised of 4 bytes as follows:

• First byte(printer information)

Bit	Off/On	Hex	Decimal	Function
0	Off	00	0	Not used. Fixed to Off
1	Off	00	0	Not used. Fixed to Off
2	Off	00	0	Drawer kick-out connector pin 3 is LOW
	On	04	4	Drawer kick-out connector pin 3 is HIGH
3	Off	00	0	On-line
	On	08	8	Off-line
4	On	10	16	Not used. Fixed to On
5	Off	00	0	Cover is close
	On	20	32	Cover is open
6	Off	00	0	Paper is not being fed by the paper feed button
	On	40	64	Paper is being fed by the paper feed butto
7	Off	00	0	Not used. Fixed to Off

• Second byte(printer information)

Bit	Off/On	Hex	Decimal	Function
0	Off	00	0	Not used. Fixed to Off
1	Off	00	0	Not used. Fixed to Off
2	Off	00	0	No mechanical error
	On	04	4	Mechanical error
3	Off	00	0	No auto cutter error
	On	08	8	Auto cutter error occurred
4	Off	00	0	Not used. Fixed to Off
5	Off	00	0	No unrecoverable error
	On	20	32	Unrecoverable error
6	Off	00	0	No automatically recoverable error
	On	40	64	Automatically recoverable error occurred
7	Off	00	0	Not used. Fixed to Off

– If mechanical error (bit 2) or auto-cutter error (bit 3) occurs due to paper jams or the like, it is possible to recover by correcting a cause of the error and executing ENQ in real time mode.

- If an unrecoverable error (bit 5) occurs, turn off the power as soon as possible.

• Third byte (paper sensor information)

Bit	Off/On	Hex	Decimal	Function
0,1	Off	00	0	Paper near end sensor: paper adequate
	On	03	3	Paper near end sensor: paper near end
2,3	Off	00	0	Paper end sensor: paper present
	On	0C	12	Paper end sensor: no paper present
4	Off	00	0	Not used. Fixed to Off
5	Off	00	0	Not used. Fixed to Off
6	Off	00	0	Not used. Fixed to Off
7	Off	00	0	Not used. Fixed to Off

• Fourth byte (paper sensor information)

Bit	Off/On	Hex	Decimal	Function
0	On	01	1	Not used. Fixed to On
1	On	02	2	Not used. Fixed to On
2	On	04	4	Not used. Fixed to On
3	On	08	8	Not used. Fixed to On
4	Off	00	0	Not used. Fixed to Off
5	Off	00	0	Not used. Fixed to Off
6	Off	00	0	Not used. Fixed to Off
7	Off	00	0	Not used. Fixed to Off

Differences: None

GS f

Function: **Select font for HRI characters**

Code:

ASCII	GS	f	n
Hex	1D	66	n
Decimal	29	102	n

Range: n=0, 1, 48, 49

Default: n=0

Printers: All printer models except for **SRP-270, SRP-275, SRP-280, SRP-500**

Description: This command selects a font for the HRI(Human Readable Interpretation) characters used when printing a bar code, using n as follows:

n	Font
0, 48	Font A
1, 49	Font B

Remarks:
- The setting of this command is applied to only HRI characters.
- The printing position of HRI characters are specified by GS H.
- The configurations of Font A and B vary depending on the printer model.

Differences: Configuration of font:

- **SRP-350:**
  Font A (12 x 24), Font B (9 x 17)
- **SPP-R200, SRP-350plus, SRP-350plusN, SRP-352plus, SRP-352plusN, SRP-350plusV, SRP-350plusM:**
  FrontA(12x24, Font B(9x24)

GS h

Function: **Selects bar code height**

Code:

ASCII	GS	h	n
Hex	1D	68	n
Decimal	29	104	n

Range: 1 ≤ n ≤ 255

Default: n=162

Printers: All printer models except for **SRP-270, SRP-275, SRP-280, SRP-500**

Description: This command sets the height of the bar code to n dots.

Remarks:
- The unit of n depends on the printer model.
- The setting of this command remains effective until ESC @, printer reset or power cycling is executed.

Differences: Unit of one dot:

- **SRP-270, SRP-280:**
  0.176 mm (1/144 inch)
- **STP-131, SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-350plusV, SRP-350plusM:**
  0.141mm(1/180 inch)
- **STP-103, SPP-R200, SRP-352plus, SRP-352plusN:**
  0.125mm(1/203 inch)

GS k

Function: **Print bar code**

Code:

①	**ASCII**	GS	k	m	d1...dk	NUL
	Hex	1D	6B	m	d1...dk	NUL
	Decimal	29	107	m	d1...dk	NUL
②	**ASCII**	GS	k	m	n	d1...dn
	Hex	1D	6B	m	n	d1...dn
	Decimal	29	107	m	n	d1...dn

Range: ① 0 ≤ m ≤ 6 ② 65 ≤ m ≤ 73
K, m, n depend on the barcode system

Default: None

Printers: All printer models except for **SRP-270, SRP-275, SRP-280, SRP-500**

Description: ■ This command selects a bar code system and prints the bar code.
- k indicates the number of bytes of bar code data.
- n specifies the number of bytes of bar code data.
- d specifies the character code data of the bar code data to be printed.

For range ①

m	Bar Code System	Range of k	Range of d
0	UPC-A	11 ≤ k ≤ 12	48 ≤ d ≤ 57
1	UPC-E	11 ≤ k ≤ 12	48 ≤ d ≤ 57
2	JAN13(EAN)	12 ≤ k ≤ 13	48 ≤ d ≤ 57
3	JAN8(EAN)	7 ≤ k ≤ 8	48 ≤ d ≤ 57
4	CODE39	1 ≤ k	48 ≤ d ≤ 57, 65 ≤ d ≤ 90, d=32,36,37,43,45,46,47
5	ITF	1 ≤ k (even number)	48 ≤ d ≤ 57
6	CODABAR	1 ≤ k	48 ≤ d ≤ 57, 65 ≤ d ≤ 68, d=36,43,45,46,47,58

For range ②

m	Bar Code System	Range of k	Range of d
65	UPC-A	11 ≤ n ≤ 12	48 ≤ d ≤ 57
66	UPC-E	11 ≤ n ≤ 12	48 ≤ d ≤ 57
67	JAN13(EAN)	12 ≤ n ≤ 13	48 ≤ d ≤ 57
68	JAN8(EAN)	7 ≤ n ≤ 8	48 ≤ d ≤ 57
69	CODE39	1 ≤ n ≤ 255	48 ≤ d ≤ 57, 65 ≤ d ≤ 90, d=32,36,37,43,45,46,47
70	ITF	1 ≤ n ≤ 255 (even number)	48 ≤ d ≤ 57
71	CODABAR	1 ≤ n ≤ 255	48 ≤ d ≤ 57, 65 ≤ d ≤ 68, d=36,43,45,46,47,58
72	CODE93	1 ≤ n ≤ 255	0 ≤ d ≤ 127
73	CODE128	2 ≤ n ≤ 255	0 ≤ d ≤ 127

Remarks:

- The bar code width exceeding the print area can not be specified.
- Except for character size and upside-down printing mode, none of print mode such as emphasized, double-strike, etc, affects the printing of the barcode.
- The quiet zone of the bar code (left and right spaces of the bar code) should be considered when using this command.

Differences: None

GS r

Function: **Transmit status**

Code:

ASCII	GS	r	n
Hex	1D	72	n
Decimal	29	114	n

Range: n=1, 2, 49, 50

Default: None

Printers: **All printer models**

Description: The command transmits the status specified by n as follows:

n	Function
1, 49	Transmits paper sensor status
2, 50	Transmits drawer kick-out connector status

Remarks:

■ The status is one byte.

■ The status to be transmitted is as follows:

• Paper sensor status (n=1, 49):

Bit	Off/On	Hex	Decimal	Function
0, 1	Off	00	0	Paper near-end sensor: Paper adequate
	On	03	3	Paper near-end sensor: Paper near end
2, 3	Off	00	0	Paper end sensor: Paper present
	On	0C	12	Paper end sensor: Paper not present
4	Off	00	0	Fixed
5	Off	00	0	Reserved
6	Off	00	0	Reserved
7	Off	00	0	Fixed

Bits 2 and 3: This command can not be executed when the printer is offline due to the lack of paper. Therefore, the status of bit 2 (1) and bit 3 (1) is not transmitted.

- Drawer kick-out connector status (n=2, 50):

Bit	Off/On	Hex	Decimal	Function
0	Off	00	0	Drawer kick-out connector pin 3 is LOW
	On	01	1	Drawer kick-out connector pin 3 is HIGH
1	Off	00	0	Reserved
2	Off	00	0	Reserved
3	Off	00	0	Reserved
4	Off	00	0	Fixed
5	Off	00	0	Reserved
6	Off	00	0	Reserved
7	Off	00	0	Fixed

■ This command can be executed in real-time mode using DLE.

Differences: None

GS v 0

Function: **Print raster bit image.**

Code:

ASCII	GS	v	0	m	xL xH yL yH d1...dk
Hex	1D	76	30	m	xL xH yL yH d1...dk
Decimal	29	118	48	m	xL xH yL yH d1...dk

Range:
0 ≤ m ≤ 3, 48 ≤ m ≤ 51
1 ≤ (xL + xH x 256) ≤ 128 (0 ≤ xL ≤ 128, xh=0)
1 ≤ (yL + yH x 256) ≤ 4095 (0 ≤ yL ≤ 255, 0 ≤ yH ≤ 15)
0 ≤ d ≤ 255
k = (xL + xH x 256) x (yL + yH x 256)

Default: None

Printers: All printer models except for **SRP-270, SRP-275, SRP-280, SRP-500**

Description:
■ This command prints a raster bit image according to the mode defined by m.

DPI : Dots per Inch (25.4mm)

m	Mode	Vertical dot density (DPI)	Horizontal dot density (DPI)
0, 48	Normal	203	203
1, 49	Double-width	203	203/2
2, 50	Double-height	203/2	203
3, 51	Quadruple	203/2	203/2

- xL, xH specifies (xL + xH x 256) byte(s) in the horizontal direction for the bit image.
- yL, yH specifies (yL + yH x 256) dot(s) in the vertical direction for the bit image.
- d specifies the definition data of the bit image data.

Remarks:
■ In standard mode, this command is effective when the printer buffer is empty and the printer is in the beginning of the line. If the buffer is not empty, after processing m, the printer treats the following data as normal data.
■ In page mode, the bit image is stored in the print buffer, not being printed.
■ None of the print modes such as emphasized, double-strike, etc, affects the printing of the bit image.

■ The default dot density set by GS L is applied to printing of the bit image.

Differences:

■ **STP-103, SPP-R200, SRP-352plus, SRP-352plusN:**

DPI : Dots per Inch (25.4mm)

m	Mode	Vertical dot density (DPI)	Horizontal dot density (DPI)
0, 48	Normal	203	203
1, 49	Double-width	203	203/2
2, 50	Double-height	203/2	203
3, 51	Quadruple	203/2	203/2

■ **STP-131, SRP-350, SRP350N, SRP-350plus, SRP-350plusN, SRP-350plusV, SRP-350plusM:**

DPI : Dots per Inch (25.4mm)

m	Mode	Vertical dot density (DPI)	Horizontal dot density (DPI)
0, 48	Normal	180	180
1, 49	Double-width	180	90
2, 50	Double-height	90	180
3, 51	Quadruple	90	90

GS w

Function: **Set bar code width**

Code:

ASCII	GS	w	n
Hex	1D	77	n
Decimal	29	119	n

Range: 2 ≤ n ≤ 6

Default: n=3

Printers: All printer models except for **SRP-270, SRP-275, SRP-280, SRP-500**

Description: ■ This command sets the horizontal size of the bar code, using n as follows:

n	**Multi-level bar code module width (mm)**	**Binary-level bar code**	
		Thin element width (mm)	**Thick element width (mm)**
2	0.250	0.250	0.625
3	0.375	0.375	1.000
4	0.500	0.500	1.250
5	0.625	0.625	1.625
6	0.750	0.750	2.000

- n specifies the bar code module width.

Remarks: ■ The setting of this command is effective for the following bar codes:
- Multi-level bar codes (UPC-A, UPC-E, JAN13, HAN8, CODE93, CODE128)
- Binary-level bar codes (CODE39, ITF, CODABAR)

■ The setting of this command remains effective until ESC @, printer reset or power cycling is executed.

Differences: ■ **STP-131, SRP-350, SRP-350N, SRP-350plus, SRP-350plusN, SRP-350plusV, SRP-350plusM:**

n	Multi-level bar code module width (mm)	Binary-level bar code	
		Thin element width (mm)	Thick element width (mm)
2	0.282	0.282	0.706
3	0.423	0.423	1.129
4	0.564	0.564	1.411
5	0.706	0.706	1.834
6	0.847	0.847	2.258